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ON THE COVER:
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The award-winning Point K2 Top from Vitap will enable you to make 80-90 cabinets a day in an eight-hour shift.



Craic for Combilift

Combilift celebrates as it moves into a new 50 million Euro factory 20 years after the first truck rolled off the production line.

If you were to meet Robert Moffett or Martin McVicar in your local, there's no doubt the conversation would flow easily. You'd very quickly realise they were from Ireland, but it's very, very unlikely you'd ever get to learn much about their remarkable achievements. Despite being exceptionally talented engineers and businessmen who have immense pride in both their workforce and a product line they've invented and turned into a world leader, they are also remarkably modest.

Joint owners of the materials handling specialist, Combilift, Robert and Martin's story has been one of courage, hard work, determination and innovation. It's a story that in just 20 years has seen the idea they first produced in a 50,000 square foot factory in the heart of rural Ireland take 85 countries by storm and establish itself as the market leader in a niche it's taken as its own. So good are the forklifts Combilift manufactures at increasing the available warehouse space of

its clients, that the company has risen meteorically from zero to 250 million Euros in 20 years and, with the opening of their new 50 million Euro factory in May 2018, Robert and Martin are poised to reach their next target, 500 million Euros, in the next few years. Production last year topped 5,000 trucks and as a testament to the engineering quality, the very first truck ever built (a working model they managed to prise away from its owner for the company's 20-year anniversary celebrations) stood proudly in a corner of the new entrance hall. Small wonder that when they had their official opening and anniversary celebrations, politicians and dignitaries came from as far away as Australia to add their congratulations – and enjoy a proper Irish celebration.

"Robert and I used to work together in the Moffett forklift business, so forklifts are what we really know about," Martin McVicar told Furniture Journal in an exclusive interview at the new factory in County



Robert Moffett & Martin McVicar



Monaghan. "When the Moffett business was sold, I did not want to work for a public company. Neither did Robert. When I was working for a private company, I was valued for what I did; I was recognised, and that was the catalyst to do something on my own. I'd worked with Robert previously, so the two of us got together very quickly and we established Combilift in March 1998."

With over 200 manufacturers of forklift trucks, Robert and Martin knew there was no way of competing globally by making traditional forklift trucks, so they decided to focus on niche markets. "The initial niche market we focussed on was the handling of long goods," explains Martin. "That was really how the Combilift multidirectional forklift came about. We developed a forklift that could drive forwards and backwards like a regular forklift truck, but with wheels that could turn so it could travel laterally right and left like a sideloader. It's a multi-directional forklift truck that can handle long products in

less space, more safely. Those are the key selling points."

For the first ten years, Combilift's product focus was very much on long load handling and that remains central to the success of the Combilift business today. "We still build long load handling equipment," says Martin, "But in the last ten years, we've developed a range of products for the warehousing market – products like the Aisle Master – for customers in distribution and palletised storage. In the last five years, we've focussed on heavy goods handling with the straddle carrier. More recently, we've turned our attention to pedestrian equipment. We've had a few pedestrian models in the marketplace for the last three or four years, starting with the VWR, but here, at the new factory opening, we're launching a new additional range of pedestrian equipment."

So, what drives Combilift's incredible thirst for innovation? "We're not interested in making regular fork lift trucks," assures

Martin. "We're always looking to identify niches where we can become the number one player. That said, our designs don't come from us sitting in a dark room, or in meetings to discuss what the next Combilift should look like. They come from listening to our customers, identifying what challenges they have, or what material handling issues they encounter. If we can solve them, that's an opportunity for our business. That's where a lot of our product innovation comes from. As a business, 7% of our revenue goes into research and development."

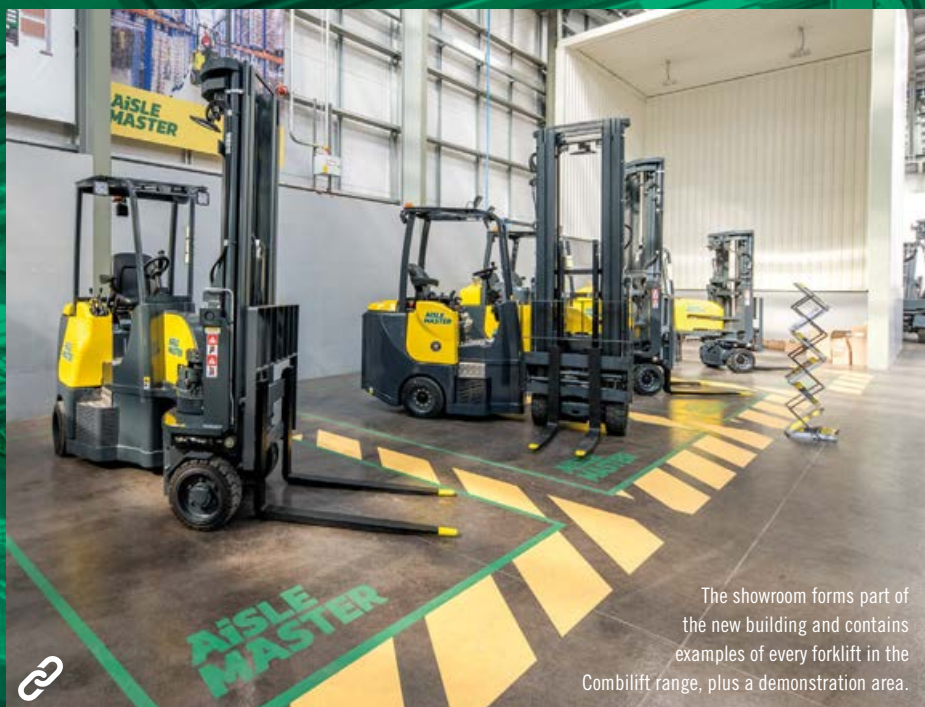
Even the new factory is a model of innovation. Built on a 100-acre plot, the first sod was turned in August 2015 on a project that was purpose designed: "A traditional manufacturing plant is rectangular," says Martin. "We designed this plant as an L-shape so the administration block could be at the centre of the L. It means our engineers, or people in purchasing, don't have such a distance to walk to the offices.



This plant is 11 acres under one roof. That's equivalent to over six soccer pitches. It's set up for fabrication with sections for assembly, painting, testing and shipping and we've set up four mobile forklift assembly lines that move at a creep speed. It moves at about three metres every 50 minutes. There is one forklift per hour coming off the line, so the four lines enable us to produce a Combilift every fifteen minutes. This plant is designed so we can actually double the output in a single shift, so now we have the capability to reduce our lead times. We have the workforce and the plant to do it. Our biggest challenge at the moment is to get our supply base to grow with demand."

Most companies can either mass produce or, if they are very small, custom build. Combilift has a mass production plant capability but still with customisation down the assembly lines – one of the company's greatest strengths. We're not just talking a black model or a silver model here. For North America, Combilift builds trucks with larger cabins; for the European market, some customers want models with larger wheels for working in hardcore indoor/outdoor situations. For UK customers, where warehouse space is restricted, the design team has even developed models where the operator can stand rather than sit so the aisle can be made even smaller. And every single Combilift – even the giant straddle carriers – is designed to unbolt so it can fit into a shipping container for cost-effective export.

With all companies taking more time to analyse their return on investment, most want to know what other value they are going to get out of the truck they are proposing to buy. Combilift isn't just selling forklifts, it's selling space-saving: "We have a team of eight engineers in house who work on warehouse design - and that's something we offer free of charge," says Martin. "We



The showroom forms part of the new building and contains examples of every forklift in the Combilift range, plus a demonstration area.





Josh Moffett: "We get an enquiry from our dealers with details of the load and the application they need and we'll sketch it up using SolidWorks. They look it over with the client and either confirm it's what they need, or we modify and customise it until it does the job exactly. Once everyone is happy, we start the engineering process. All the load bearing calculations are done, then we schedule it into the build and give the lead time."

"We have our own CNC plasma cutting, drilling and milling machines. Once all the components are cut, they are welded in one of our 60 welding bays, then everything is blasted. We have three shot blasters that properly clean the steel before it's taken into the paint lines. We use a water-based paint but we can also offer marine spec paint. We have two automated paint lines, a five-tonne line and a 10-tonne line. We also have two static ovens for large sections up to 14 metres length. All the parts then go to the assembly area."

"The chassis comes on at the start of a 90-metre line and each operator has 50 minutes to do his process. In that time, it will move three metres. The task could be installing batteries, adding the wheels, putting in the wiring loom, adding the mast. We've worked on production timing for years, so we know each stage has an adequate time. If we need to speed up the process, we'll add three or four people to the line."

"Stores constantly take away the empty trolleys and feed the line with the right parts at the right time. Stores is a vital part of the process. The parts are always there at the side of the operator when he needs them. Adding customise parts like a light means adjusting the timing slightly. If it was an eight tonne with a special attachment, or with special hydraulics, or a special mast, the machine might be transferred to one of the slower moving lines. Line one is the fastest, line four the slowest."

"A very high percentage of all the trucks we make is customised. The Aisle Master is the only product you could say is somewhat standard. The C4000s, the C6000 and C8000s on up to 25 tonne, we make the platform lengths to suit the customers application. Then there's an endless list of options from air conditioning to blue lights. The straddle carriers are the only static builds that are not produced on a moving line."



There are four lines that move at three metres every 50 minutes



One of three shot blasters



Straddle Carriers



The paint shop includes a 14 metre static oven



Plasma cutting



will take a drawing of the customer's existing facility and prepare an illustration that demonstrates how much more storage facility they could get if they were using Combilift products, or how much more efficiently we could lay the plant out. We are unique in that sense, as most forklift manufacturers don't get into the warehouse design aspect. We do, and it enables us to customise the product in order to maximise that client's storage space and his return on investment."

When companies grow rapidly, it's all too easy for those at the top to lose touch. Not

Robert and Martin. They are as committed and as enthusiastic as they ever were, though Martin freely admits, these days he isn't so much involved with the nitty-gritty of the design. He "dabbles" in it – his words. He sees his role more as a conduit between the marketplace and the designers, translating customers' challenges into what the product could look like. Robert then gets involved in the detail to make it happen. It's a good combination. What they have behind them is a good and committed workforce that understands the ethos and the objectives of the company and clearly

knows and takes great pride in the product to which they are all contributing. Even the families of employees were invited to share in the celebrations – and more than 2,000 of them came for a factory tour. Doesn't that speak volumes about the company and its standing in the local community? It's way more than Robert or Martin would confess to over a Guinness.

For more information from Combilift, call 00353 47 80500, or download the free Furniture Journal app and tap www.combilift.com or any of the pictures displaying a link sign for product information.



Martin McVicar: "We see there's a major appetite in the marketplace where manufacturing and distribution companies want to remove sit-down forklifts from working areas. A pedestrian operated truck is much preferred in the manufacturing area because there is greater visibility all around. It's safer both for the operator and the people in the factory. We've now introduced a new model called the Combilift CS - it's like a counter-balance forklift truck that's pedestrian operated. We're also launching some high capacity pedestrian equipment."

"A traditional powered pallet truck might be capable of lifting 2,000kg. We have some products on display in the showroom that are capable of lifting five tonnes, ten tonnes, even sixteen – big capacity – so even around production areas where manufacturers are moving pallet loads of heavy wood or panels, we can offer a pedestrian truck that will move those heavy loads around."



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Piranha Pro ATC 2030



W Exhibition Newcomers

The UK's only woodworking machinery and materials show, the W Exhibition, is just a few months away, and as the woodworking industry gear up for the biggest show to date, the latest newcomers have been announced.

First time exhibitor, Radecal Machine Sales, will be presenting its Piranha and Spartan mid-range CNC range at the four-day event. "Our customers were asking us why we were not exhibiting at the W exhibition and we stood up and took notice," explains Nikko Liadopoulos, Sales & Marketing Manager at Radecal Machine Sales. "We manufacture CNC routers and have historically exhibited at signage exhibitions. The woodworking sector is a massive market for the company and it's the right time for us to be part of a big machinery and materials show. With woodworkers predominantly using 8x4 meter and jumbo sheets, we've chosen to exhibit machines that reflect this trend and also include quick release and automatic tool changers."

Providing lifting equipment for manual handling, Tawi UK will also be exhibiting its vast range of handling equipment for the

first time at the show. "We're focusing our attention heavily on the timber industry and the W Exhibition is the ideal platform for us to promote our products," explains Danielle Cheshire, Sales & Marketing Manager at Tawi UK. "The woodworking sector is a key market for us and, following a recent expansion, we're now in a position to promote our handling solutions further." Tawi's stand will focus on its range of vacuum lifters that will be demonstrated at the show.

Following a six-year hiatus, Fercell Engineering will be returning to the W Exhibition. The stand, which will be designed around a large filter, will feature a range of woodwaste management products from shredders to briquette presses and offer visitors a fully interactive experience. Natalie Owen, Digital Marketing Executive at Fercell Engineering explains, "Fercell Engineering has evolved a lot in recent years and it is time for us to promote our widening product portfolio to the woodworking sector. As a manufacturer of recycling and ventilation products, people often think we only work with large companies but that is a

More first-timers sign up as the UK's only woodworking show draws closer.



Fercell Superblower jet filter



The Spartan 2030



misconception. We offer solutions for all sized operations and that's the message we want to portray at the show. The W Exhibition is a great opportunity for us to engage with new and existing customers and promote our technology at a show that has the industry fully behind it."

It's not just new machinery that will be promoted at the W Exhibition. Swiss wood joining expert, Lamello, will be demonstrating its range of clever jointing systems for panels and solid timber. Shaye Chatfield, Area Sales Manager for Lamello, says, "We've had a presence at the W Exhibition before, but this year will mark our very first stand. We're looking to capture the imagination of cabinet-

makers, joiners and interior specialists who might well have used Lamello's biscuits before but haven't seen the full benefits of our range first hand." The Lamello team will also be demonstrating its newly launched Cabineo connector cabinet fitting (an efficient alternative to traditional cam and dowels), its timesaving P-System and its invisible magnetic joining element; Invis.

But the new names don't stop there. Sheet metal and ducting supplier, Norduct Ltd and cuttings specialist Metal World will also be exhibiting new technology and the latest innovations for the very first time. The W Exhibition will also welcome machinery giant Cehisa and German abrasives expert, Awuko

Abrasives, to the comprehensive line up, to further strengthen the show's product offering.

Lisa Campagnola, Event Director adds, "It's fantastic for the show and the industry that so many new names are exhibiting at the W Exhibition this September. It will be our biggest show yet and with our dedicated furniture components show, Elements, running alongside it, 2018 is set to be a great success."

The W Exhibition and Elements will be taking place from the 30 September to 3rd October 2018 at the NEC Birmingham. For more information visit www.wexhibition.co.uk or follow @W_Exhibition and @Elements_Expo on Twitter and like The W Exhibition on Facebook.

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Are you a Curvomatic Convert?

Still making curved components the hard way? There's a cheap and easy way that leaves you with more money in the job.

Ask any cabinet-maker what's involved in making curved doors, or curved components, and if he hasn't equipped his workshop with a five-axis machining centre, there's sure to be a pause and a deep intake of breath followed by either a shaking of the head, or a very long and involved explanation. And with very good reason. Making any curved component in the traditional, time-honoured way is a task and a half. But just like CNC machining centres have made the manufacture of components a much easier, faster and more repeatable task, so too there is a very neat invention that will enable you to make curved components easily, accurately, with absolute repeatability

and in next to no time at all. It's not going to cost you CNC money either – nothing close.

Curvomatic's patented system is very, very simple. In fact, it's so simple, most converts to the Curvomatic way of doing things won't admit to using it because if it's quick and easy to make curves, the customer will also expect it to be cheap. Well, it is for you, because the time it saves is massive – but you don't have to tell your customer that!

In a nut shell, once you've cut the formers from some 18mm board you simply slide the extrusions together and lay them over the formers to create an incredibly strong mould. These moulds can then be used in vacuum or hydraulic presses. Curvomatic does however also provide a beautifully simple pressing system by laying another layer of the extrusions over the work and strapping it down with 5 tonne ratchets.

You think nothing could be so easy? There has to be a catch, right? Believe me, some of the biggest names in cabinet-making,

joinery, yacht-building, acrylic fabrication and aerospace are Curvomatic converts, and they are producing anything from replacement windscreens for military vehicles to cast sections of oil pipeline insulation. With the new design extruded beams for their pressing system which have sliding fittings for the ratchets and a deep slot into which the formers sit, the whole process has become quicker and easier, again making curves even easier to produce.

Still not convinced? Pop along to see Curvomatic at the WV exhibition in Birmingham between 30th September and 3rd October – stand number N305 - and watch the live demonstrations on the Curvomatic stand. Or, if you can't wait to get your hands on the simplest and most effective way of producing curved components ever invented, call Curvomatic on 0116 269 2212 or, if you're reading this edition with the free, interactive Furniture Journal app, watch the video by touching the main picture on this page.



Titillating and Tantalising

Interprint announces a new event for autumn 2018 to replace the much-loved Furniture Days.

Not since the days of the great Bard, William Shakespeare, has the art of titillating and tantalising so mercilessly, or skilfully been exploited as it is by the Interprint team ahead of a décor event. Since 2007, we've been teased with hints about what visitors to the Interprint Furniture Days might expect – and, in the closing days of each autumn for a decade, they never failed to deliver surprises, introduced with a little theatre and the panache one might expect from one of the industry's creative talents. But this year, after a bleak autumn with no Furniture Days to look forward to in 2017, Team Interprint has gone above and beyond for 2018. The autumn will mark the launch of a brand new and even more spectacular event for those wanting insight into interior design trends for the furniture industry – and the new event will be known as “HUB – Interprint Interior Festival”.

Knowing the talents of the effervescent design guru, Salvatore Figliuzzi, and his team of creatives, doesn't the thought of an entire festival whet the appetite and arouse the curiosity somewhat? Not that we're allowed to tell you too much about it, of course, other than it will be hosted in the SANAA Building on the Zeche Zollverein Unesco World Heritage Site in Essen on 14th and 15th November 2018.

The significance of the word HUB in the title of the event gives a clue to the content: it's a place, a central point, where important information converges; a place where people who influence interior design meet. And in Interprint speak, that usually means an opportunity for manufacturers, designers and decision-makers in interior design to get together and explore synergies and innovations that will influence the décors we will see launched in 2019.

In his play Macbeth, the great Bard wrote *If you can look into the seeds of time and say which grain will grow and which will not, speak then unto me*. He'd clearly heard of Interprint because that's more than likely what the “HUB – Interprint Interior Festival” will be all about: shaping and predicting the best-selling décors for the year ahead.

We will endeavour to bring you right up to speed with the 2019 Interprint décors in Furniture Journal's January Design & Décors edition, but for the moment, watch out for announcements about the programme, the speakers, the exhibitors and the topics.

For more information on Interprint, or to see how many of Interprint's earlier predictions became market favourites, visit www.interprint.com



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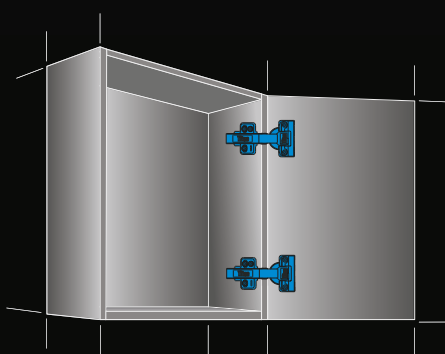
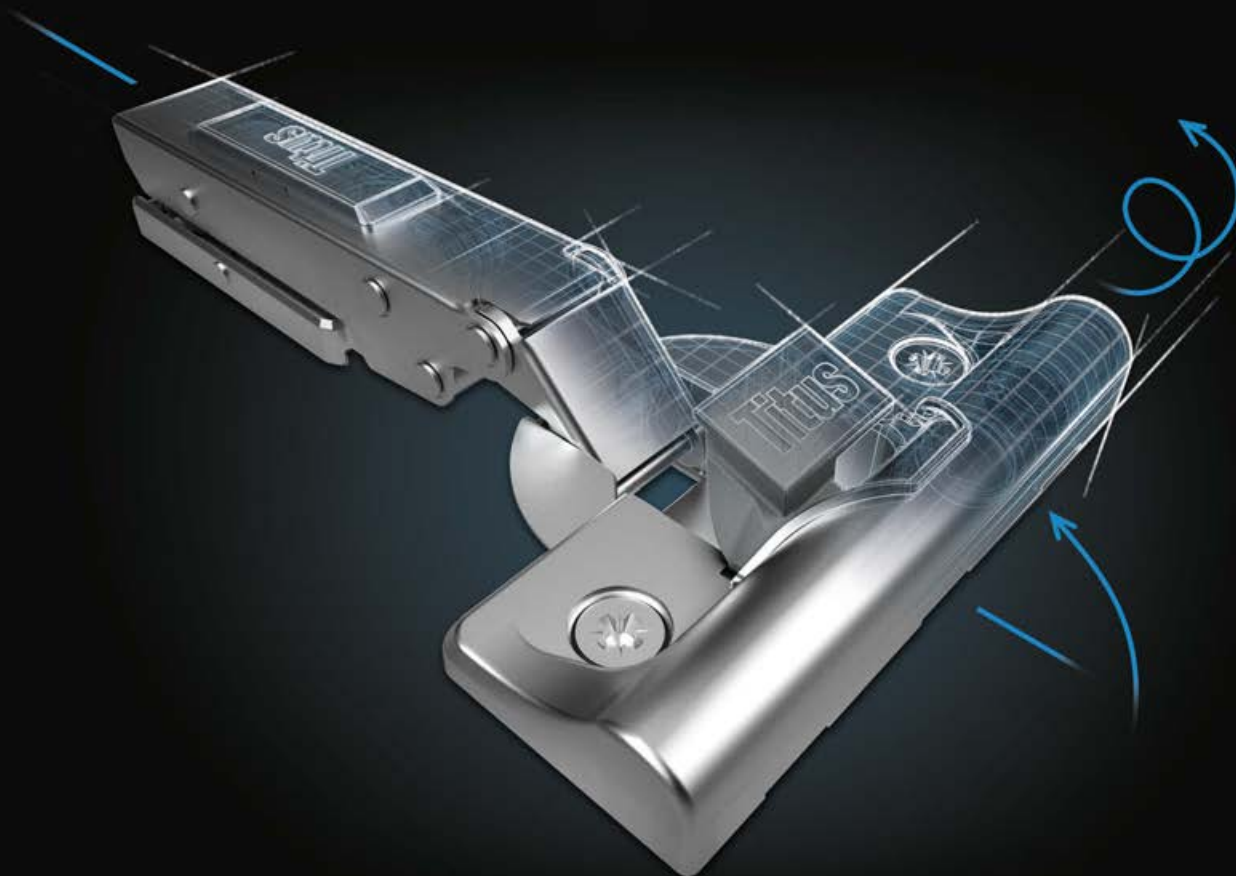
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Hawa Concepta pivot folding door

Flexibility from Slides

There has been a massive shift in recent years towards creating open plan living spaces and finding ways to bring the outside in. Sliding door systems offer one solution, and as one of the largest providers of sliding door gear in the UK, Häfele offers a particularly wide range covering most applications.

“Sliding Door systems don’t need to be restricted to structural applications,” says Häfele UK’s Product Group Manager, Elizabeth Briggs. “There are a large variety of systems that allow furniture manufacturers to complete sleek, minimal designs and provide furniture solutions that make the most use of space in the home:

“At Häfele, we have been seeing a gradual increase in the trend for ‘European style’ door solutions to help hide away sections of a room – perfect for open and broken plan living where space needs to fulfil both practical and decorative functions. The Concepta system from Hawa is one solution to consider: it’s a cabinet door system that offers a pivot sliding option for one door, or folding pivot sliding system for two or more doors. The doors recede into a pocket within the cabinet run and don’t require a floor channel so they can be used in different room

settings with no obstructions. A unique scissor action is used to move the doors on the pivot sliding system and it can hold doors weighing up to 25kg each.

“Sliding systems also provide a great space-saving alternative to traditional opening mechanisms in cabinets. There are mechanisms available on the market to accommodate any number of panels and sizes. The Eku Frontino system is one of Häfele’s favourite systems, as it provides a truly flush finish across cabinet doors rather than a stepped finish, and it can support door weights up to 40kg depending on the running system.

“Häfele manufactures its own brand of sliding door gear, Slido, and these have been purpose designed to help save time and money. Our top hung Classic system is the perfect example of this, as the classic tracking can be used across all weights of door and cabinet sizes and only the running gear changes depending on the weight of door required,” says Elizabeth. “This offers larger furniture manufacturers the ability to stock the track in larger quantities and use exactly the same tooling across all their cabinetry, as the easy-to-install running gear is fitted at a later stage. All of Häfele’s own brand ranges are also fully

Häfele UK’s Elizabeth Briggs explains how sliding door gear can help to achieve a multitude of desired room finishes.



Elizabeth Briggs



supported by a guarantee, and this is valid for 10 years across all Slido products.”

Sliding Door mechanisms offer a practical solution to achieving openings in virtually any small space and really come into their own when customers are trying to maximise the use of space through moveable walls and room dividers. “A system like the Slido Design 80-M achieves a floating finish on the wall through clever use of hidden tracks and fixings and it’s ideal for areas that leave minimal room for the swing arc of a traditional door opening,” says

Elizabeth. “The Slido Design 80-S achieves the same finish with the additional benefit of increased soundproofing.

“Where there is a demand for ‘broken’ living rather than ‘open’ living, a system like the Room Flex offers a timber-framed solution that can divide spaces up to 4m wide. The folding action of the doors can be divided between two directions, or all doors can fold to the same side and, critically, this top hung system doesn’t need any channel guidance or rebating for the hangers or the

hinges. It is a quick and easy installation solution that’s ideal as a retro-fit room divider, or to offer as a solution for projects where laid floors already exist.”

If you’re looking to achieve a seamless look between open plan and broken living areas, between indoor and outdoors, or even in cabinets, call Häfele on 01788 542020 or visit www.hafele.co.uk To see Häfele’s sliding door mechanisms demonstrated, download the free Furniture Journal app and touch any of the pictures displaying a link sign.



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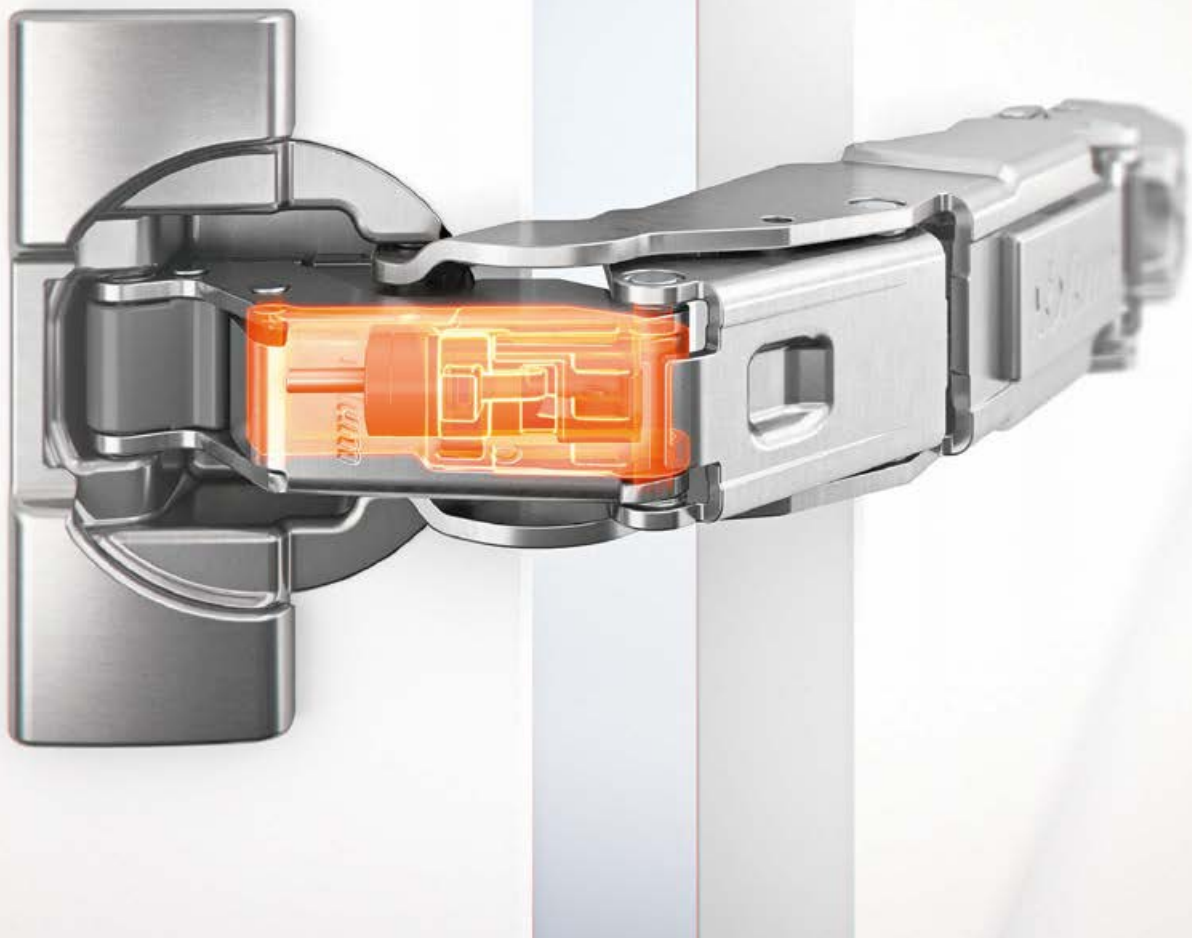


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Opening to 155°, Blum's Clip top Blumotion hinge is ideal for providing easy access to internal pull-outs.

Over the last few years, the importance of making the most of internal cabinet space has grown significantly. A number of solutions have emerged that enable awkward corners to be turned into useful storage space, among them internal pull-outs like the popular Space Tower larder solution from Blum. The use of all the existing storage in the unit, larder or wardrobe means no more wasted space – but where a hinged door is fitted, sometimes there's an issue with the hinge protruding into the space needed for the internal fitting.

If you're looking for a hinge that opens wide enough to give convenient access, and provides the soft-close quality feel consumers now expect of a hinge, Blum might just have the answer: with Blum's Clip top Blumotion 155° wide angle hinge, the tried and tested soft-close Blumotion has been integrated into a hinge arm with zero

protrusion, providing both the quality feel and improved convenience without taking up more space. And that means you can now fit Space Tower larder solutions with Clip Top Blumotion technology.

Boss and hinge arm cover caps are symmetrical so they can be used both left and right, making assembly impressively easy. The new wide-angle hinge offers the usual advantages you've come to expect from Blum such as a boss drilling depth of just 11.5 mm and three-dimensional adjustment. The Blumotion function can also be deactivated should that be required.

For more information contact Blum UK on 01908 285700, or visit www.blum.com. The Blum Easy Assembly app is also available online to support fitters. If you are reading the online edition of Furniture Journal using our free app, simply click [here](#) for a link to the Blum app on Google Play, or [here](#) for a link to the Blum app if you are an Apple user.





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Insight from

Egger publishes its new Egger Insight brochure – and it's available for browsing online.

Featuring six key trends across many different applications and showcasing 36 new décors and two new textures from its 2017-19 Decorative Collection, Egger's newly published Egger Insight provides a guide to the latest trends and décors for the KBB market.

Each chapter combines the latest design trends from Europe with Egger's woodgrain, unicolour and material décors to illustrate how

easily colour combinations can be brought to life. Featuring Feelwood, PerfectSense, contrasting textures and accent edging, Insight provides inspiration for contemporary kitchen, bedroom and bathroom design.

Trends highlighted in the publication include Modern Classics, which blends the simplicity of contemporary interiors with traditional design features, and Nordic, which has evolved beyond



H3131 ST12 Natural Davos Oak

H1122 ST22 Whitewood

H1158 ST10 Truffle
Bardolino Oak

U727 PM Stone Grey

H3406 ST38 Anthracite
Mountain LarchH1176 ST37 White
Halifax Oak

Egger

grey and white décors and is now brought to life with aqua colours and accents. A nostalgic look and feel can be created with the New Retro trend, and Materials décors not only provide a tactile and contemporary finish, but work well across a number of applications.

Elliott Fairlie, Egger's UK and Ireland Head of Décor Management, explains, "With the rise in technology and social media it is more

important than ever to keep an eye on the latest trends. Consumers have more choice than ever before and it's our role to provide them with guidance to find a solution that works for them.

"Insight not only features new trends in the market but also illustrates how Egger's décors have evolved to meet the needs of the modern consumer. By understanding which trends are

influencing people, we hope to help manufacturers unlock the true potential of our products by using Insight to create designs with a difference."

To order a copy of Insight please visit egger.com/shop. Or to view the publication online, please click [here](#) or touch any of the picture displaying a link. For more information, please contact marketinguk@egger.com





Nature Vintage Oak
Background: Roble Grigio

See. Touch.

Through the millennia, the appeal of veneers has grown and even today, veneer remains at the heart of the décor trends.

It was around 3000 years BC that the Egyptians, conscious of the scarcity of wood in their region but drawn by the beauty of its grain, first started using thin, hand-cut veneers to cover less precious surfaces. Through the ages, its appeal has grown and even today, despite the breadth of alternative décors now available, veneers remain at the centre of the latest trends.

With its latest collection of veneers, chosen for their unique and slightly innovative character, Finsa's Studio Natur range retains all the visual and tactile appeal and character of veneer and includes nine brand new veneers that move away from the standards, offering a closer approach to high-end design. The collection, which

designers will find inspirational, includes exotic species as well as more traditional timbers in natural tones. Some have even been dyed or fumed.

Finsa's Trendbook for 2018-2019 illustrates the calming effect of tinted greys – and included in the collection are two grey veneers. The richly coloured, textured Grey Vintage Oak is an aged, recycled veneer with cracks and open knots over a black background, while Grigio Oak, also grey in tone but characterised by homogeneous straight grain, provides a very versatile and elegant surface. The intense but balanced tone of this veneer creates welcoming spaces. It's an oak, but an oak with a fresh, uplifting, contemporary feel that can be combined with



Kandy Ebony



Rustic Oak



Mumbai Rosewood

Enjoy.

deep or soft melamines for a striking balance of light and dark.

The collection also includes statement veneers, like Mumbai Rosewood. It is a refined, reconstituted design characterised by the arrangement of the dark, almost black veins of authentic rosewood over a mid-tone brown background. A true celebration of a rare tropical timber, this vivid veneer combines natural woods to create a sustainable alternative to the endangered Asian rosewood. Kandy Ebony, another intense exotic, also provides strong contrasts that offer a new option for darker interiors. The elegant finish is characterised by a linear arrangement of very dark heartwood alternating with pink streaks.

For a more neutral look, Studio Natur includes best-selling oaks such as Rustic Oak and Nature Vintage Oak. These have all the ingredients of natural wood in one single veneer. Unique and full of character, the look of these oaks includes knots, natural cracks and light colour contrasts that are ideal for calm rustic spaces and combine well with many colours.

The Studio Natur collection is available on top quality 19mm MDF in 2440 x 1220mm sheets. Other formats and thicknesses are available upon request.

For inspiration, take a look at **Studio Natur** using the free Furniture Journal app or touch the linked pictures for more information. Alternatively, call Finsa on 0151 652 3329 or visit www.finsa.com

Grey Vintage Oak





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HÄFELE



Vienna ST-0006-4SL1-XL
Background: Moscow ST-0005-4SH-XL

The New Stone Age

Early humans first began to appreciate the merits of stone almost three-and-a-half million years ago. Through the ages, we've learned to shape it, quarry it, mine it and polish it, and gradually, the uses we've found for this remarkable natural material have diversified from tools to buildings, gardens to decoration and even jewellery.

Tactile, visually appealing and versatile, stone products have long been appreciated by interior designers and architects, not only as building materials but as decorative materials for both exterior and interior use. In combination with other materials, especially other natural materials like wood and metal, stone provides ambience, comfort and familiarity to both traditional and

contemporary interiors – and nowadays, it is also becoming more widely used to enhance distinctive pieces of furniture.

Traditionally, working stone has always been the job of specialists equipped with tools for building, cutting, shaping, or polishing. Where stone has been used in furniture, more often than not, furniture and interior manufacturers call in specialists who can handle the task. However, with a brand-new real stone product available from Elland-based Decorative Panels Lamination, there's no longer a need to call in subcontractors if that prestigious interior project, or that custom-made cabinet you're working on demands the distinctive look of stone. Real Stone Veneer is supplied ready

Alongside gloss, glass, matt and more, the dp-limitless collection includes seven totally unique and absolutely beautiful real stone veneer surfaces.

Seoul ST-0001-4SK1-XL



Background: Helsinki ST-0003-4SN-XL
Clockwise from top left:
 Rome ST-0004-4QP-XL, Madrid ST-0002-4QO-XL
 Tokyo ST-0007-4QM-XL, Furniture created with Helsinki

laminated to the board of your choice and can be cut, shaped and edged with woodworking tools.

Part of the dp-limitless collection, Real Stone Veneer is a unique product that, as the name suggests, is a real quartzite or slate veneer that's been laminated to a panel – and it's perfect for feature boards, corporate foyers, hotel reception desks, etc. The real stone veneer is “quarried” in India using an unusual technique that involves coating a sheet-size area of stone with a resin while it's still in situ in the quarry, leaving it for six hours until it sets, then quite literally peeling the resin back from the rock face so a layer of stone around 2mm thick is removed with a resin backing. This innovative product is then laminated onto a substrate with PUR adhesive, making full use of the new lamination line installed at Decorative Panels Lamination.

As with all natural products, every sheet is absolutely unique and displays the beautiful stone structures, colours, sparkles and textures of the material perfectly. The surface is pre-sealed, so no further surface protection is necessary – and it can be laminated to any kind of panel required, even honeycomb panels, to provide an easy-to-use, easy-to-handle product that replaces the need for solid stone.

The dp-limitless Real Stone Veneer collection currently includes seven quite different real stone veneers, each named after cities from around the world. Choose from smooth matt, gently marbled Moscow in on-trend dark grey; or opt for Helsinki if you need a touch more sheen. Seoul adds lightness and patterning, yet retains a matt surface, while copper tones and pewter blend in the lightly textured surface of Vienna. For more surface structure, Madrid

and Rome offer depth, shimmer and texture – but for the ultimate in tactile appeal, take a look at the lustrous Tokyo. Like the city itself, the deeply striated surface of Tokyo is illuminated with reflected light, picking out the greys and silvers in a surface like no other.

Although any of the options in the dp-limitless Real Stone Veneer collection can be laminated in bulk for those who need it, for bespoke work the new lamination line enables Decorative Panels Lamination to offer any of the seven veneers in the collection in quantities of one 2440mm x 1220mm panel up. You can even provide your own material for the substrate if you wish.

To find out more, contact Decorative Panels Lamination on 01484 658341 or download the free Furniture Journal app and tap the picture with a link sign for a direct link to the dp-limitless collection.



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Part of the dp-limitless **Technical Collection**, **Renolit Armouren** is a multi-layered decorative PVC film which offers excellent mechanical resistance and light fastness. With a highly durable anti-microbial surface finish and superior impact resistance Armouren is the perfect product for use in areas such as healthcare, public buildings, schools, hotels, restaurants and retail outlets. **Available in quantities as little as just one board.**

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Decorative Panels Components invests in automation, quality and capacity with a new edgebanding line from Biesse.

Ahead of the Game



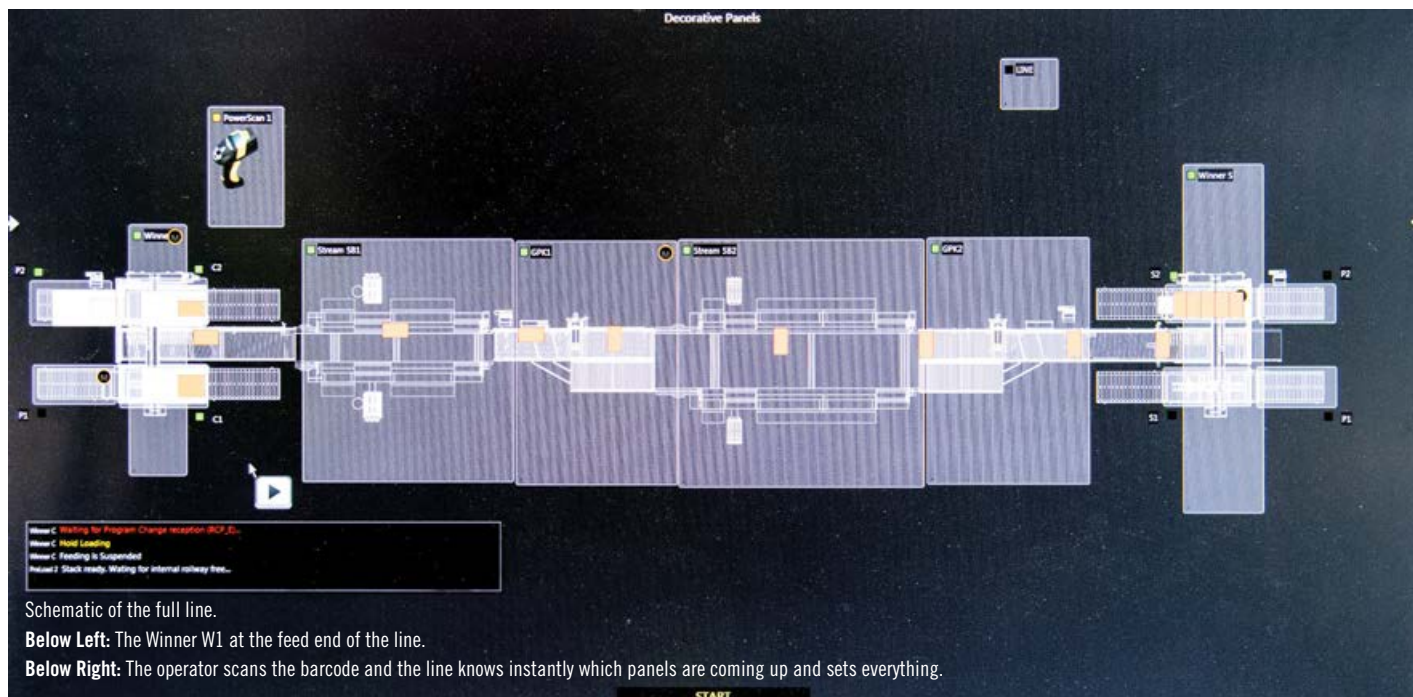
While some companies might invest in new machinery because they have little choice, and they'll specify only what's needed to do the job and to keep costs down, that's about as far removed from the philosophy of Elland-based Decorative Panels Group as one could imagine. Forward thinking, always planning ahead, often investing in first-of-its-kind technology in order to give its customer base the best quality quickly and at the best possible price, Decorative Panels Group is a shrewd but strategic investor – and the latest investment for its Components division is not only a model of modern production machinery, it's a flagship installation for the Italian company, Biesse, that showcases some of its most advanced technology.

Commissioned in January 2018, the new 59-metre, double-sided combination edgebanding line at Decorative Panels Components comprises a feeder, a first pass double-sided edgebander, a panel turner, a

second-pass double-sided edgebander, a second panel turner, a panel cleaner and an automatic stacker. It's effectively a fully automatic, barcode-driven, low batch, double-sided line – and in theory, it shouldn't exist. Somehow, using technology that's only just off the drawing board, Biesse has managed to make it work. To Biesse's credit, when Furniture Journal visited the dp-components factory six months after the line was installed, not a single fault had been encountered, nor a minute of production time lost to machine issues. It was performing faultlessly.

"We needed to replace three manually fed and stacked edgebanders," explained Group Operations Director, Phil Dalton. "We wanted to increase automation and significantly improve both quality and capacity. The new line has given us all three.

"The technology that's been added into the line to provide fast setup times includes full NC control of every machine from a barcoding system at the front and, regardless



of whether it's a large panel or a small panel, the software calculates the speed and sets up the machine. As the product arrives at the front end of the machine from the saw, it has the work order on the stack. That has a barcode. The operator scans the barcode and the line knows instantly which panels are coming up and sets everything. Instead of getting your spanner out and adjusting each motor separately, as we had to do with the old machines, within seconds the new line is ready for the next type of panel. We've gone from 15-20 minute setups between different panels to a few seconds. That's massively increased the overall effective time of the machine.

"Because we're automatically feeding and stacking, the machines can run a lot faster. Typically, on a manually fed and stacked line you might expect to achieve an absolute maximum of 21-22 panels per minute, so we're immediately getting over 30% more capacity just by specifying feeders and stackers. It improves the quality as well because there's

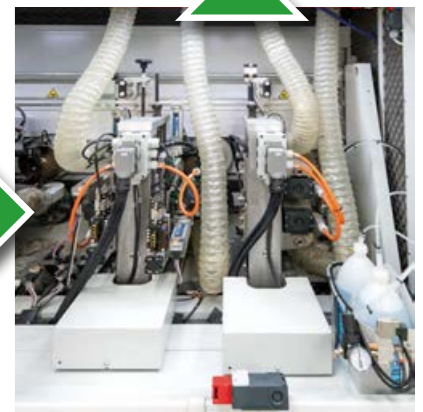
less potential for scratching and damage. Overall, the line can produce at up to 32 panels per minute and its average output is around 7,000 panels in a 12-hour shift with a 45-minute break in the middle.

"Where previously the three machines we had were running on EVA glue, we now have a good-better-best scenario. We have standard EVA as the base product, then we have a step up to PUR that gives a finer glue line. We can run white and clear as we need them, because both edgebanders are equipped with two pre-melting units and separate glue rollers that enable fast changeover. That's quite a new system for Biesse. We're one of the first to have it and it works very, very well. It's a further improvement to the finish. We're delighted with it.

"For the 'best' scenario, we specified the Biesse Airforce hot air system. This allows us to use Rehau Raukantex Pro tape, which was developed initially for use with laser equipment. That can run on the line at up to

25m minute – slightly slower than EVA or PUR, but then you really are getting a zero glueline. Compared with a laser, which can create slight voids as it scans up and down, Airforce gives 100% activation and without pockets of air, moisture ingress is prevented completely. Airforce has enabled us to brand the product coming off the line *dp-seamless*. It's allowed us to diversify and reach out to customers who want the very best the industry has to offer."

The rise in popularity of heavily textured décor materials has posed serious challenges for edgebander manufacturers but, with Biesse's double wheel, high speed tracer system, showcased at Ligna 2017, it's possible to achieve a zero glueline finish at high speed, even when applying deeply grained materials. "We specified tracers that could deal with the various heavy surface textures we needed to work with," confirmed Phil, "And both edgebanders have high speed kits on the corner rounders to process at 32 panels a minute."



Twin overhead glue systems and Airforce provide dp-components with good-better-best options.

Quality checking has been made easy by the Winner W1 at the outfeed end. It includes a quality checking station. "As the first panel passes through the machine, instead of being stacked, it rolls straight out onto a quality inspection bed that allows the operator to check it," Phil explained. "There is a simple yes and no button to accept or reject the panel. In 99% of cases, the NC has set the machine well and the first panel off has been perfect straight away, but if any minor changes do need to be made, for example if the grooving blade hasn't quite gone in deep enough, the operator can press the cross on the panel, make a minor adjustment on the NC control and continue."

The new line is all the more remarkable because Biesse has equipped it to take on the

work of the main kitchen carcass line at Decorative Panels Components, should it ever need to be taken out of service for maintenance, or go down unexpectedly for an extended period. It's a facility Phil certainly appreciates, because it adds to the company's ability to deliver on time to its customers if things ever go pear shaped.

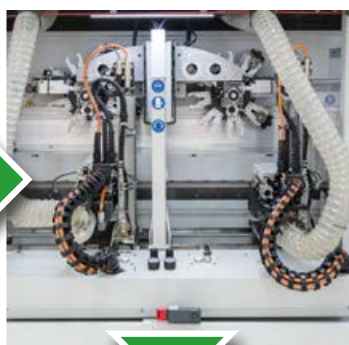
As Phil recalls, although everything happened on time and there were no hitches, the installation of the new line didn't come without its challenges: "It's a 59-metre line. We had to ensure the position of the machine didn't conflict with a number of existing mainstream extraction ducts and we couldn't shut the factory for a fortnight while the ductwork was repositioned. Making sure the

feeders and stackers didn't interfere with the ducting was a major consideration. At least we didn't have to dig pits for them. The RBO feeders and stackers work at 15 cycles per minute and pick up multiples without any need to modify the floor, and that's a major advantage none of Biesse's competitors were able to offer us.

"We knew the line would outperform the saw at times, so we had to make sure there was sufficient roller reservoir space in front of the edgebander to create a buffer between the saw and the edgebander. The edgebander is continuously sucking from the saw, especially when we're producing smaller panels, so it was really important to invest in roller space and clear an area out. Because of the length of the



The second edgebander.
Both are equipped with
Nordson VersaPUR units.



"As the first panel passes through the machine, instead of being stacked, it rolls straight out onto a quality inspection bed that allows the operator to check it. There is a simple yes and no button to accept or reject the panel."

line, we also had to install a bridge because running around it isn't really an option.

"We're absolutely delighted with it," concluded Phil. "We ordered the line in May/June 2017 and everything was delivered in full by 2nd January 2018, as agreed. We had nine artic loads arrive and there were no damages. Biesse shipped it, craned it, rolled it into position and installed everything. Within a week it was looking all but installed. It went very, very smoothly. They even put extra time on their engineers to make sure the job was done. The line has run fantastically without any intervention from Italy. We've not had to get Biesse back even once. We'd certainly recommend them."

Since the installation of the new line, Decorative Panels components has invested in a Stream B1 single-sided edgebander with the same specification as the line for producing narrow components like drawer fronts, and that will be arriving as this edition of Furniture Journal goes to print. They also have a new throughfeed drill line on order for delivery in January 2019, also from Biesse.

To find out what Biesse could do for you, call Biesse UK on 01327 300366 or email info@biesse.co.uk. Readers using the free Furniture Journal app will be able to find out more by tapping any image with a link sign.



Robbie O'Neill, Biesse UK

"This is a double-sided combination edgebanding line. There's a feeder, a first pass double-sided edgebander, then a panel turner, a second pass double-sided edgebander, another panel turner, then an automatic stacker. It has some quite unique features:

"Glue line is very important, especially as dp-components needed to be able to use it with high gloss. It's normally applied with either a PU or the Airforce system and typically, you'd choose a white glue for white panels and for a contrasting edge, a clear PU. The changeover time for this is normally really long because you have to take one off and put the next on. On average, it's about 10-15 minutes to change one side – and that's each edgebander in the line. The line at dp-components is designed to run lower batches, so what we've done is mount two glue rollers on the machine that work all the time, one with a clear glue, the other with a white. The changeover time from one to the other is five seconds. Biesse is the only manufacturer that can do that because we have a glue drive that is independent and from the top. Most other manufacturers synchronise it from the chain below. We've also put Airforce on this machine. From a cold start, it takes 60 seconds to initialise Airforce. The glue line is sorted. Gone.

"Look at the bottom of the glue roller on any edgebander and you'll find black lines. They are caused by chips being pulled out of the board and getting jammed in the glue gate. Everybody has them, except Biesse. The glue gate of the dp-components system is NC controlled. As one panel passes, the glue gate opens fully, releasing any trapped chips, then closes back to the exact position. This happens on all four sides. The result is a perfect glueline every time.

"We've also incorporated a couple of devices that will allow dp-components to process textured panels. In combination with Airforce, a textured panel is a great idea because there's no glue – but sometimes they might want to use glue. What we've done is add in an NC-controlled glue scraper that controls pressure minutely. Regardless of the texture, it will provide a consistent pressure and a consistent result without white-lining, or taking the top off the texture.

"For me, this line is the most advanced for fascias in the UK."



Optimising with Weinig

With machines from Dimter and Raimann, Weinig UK is leading the way with optimisation in rip and cross-cut sawing.

These days, saving time, saving materials and doing both safely are non-negotiables but with few areas more dangerous than sizing timber, it's an area of manufacturing in which Weinig has invested heavily.

Take the VARIORIP 310 M2, for example. In the good old days, the spindle had to be removed from the machine and set up with sawblades and spacers every time you wanted to rip to a different width. An experienced operator might manage that in 20 minutes, and if he got everything right first time he'd done well, but small batch production wasn't exactly

an option. It still isn't with many multiprops. Weinig's QuickFix changed all that. Undoing a knurled nut at the end of the spindle released the hydraulic pressure that held the keyways firm and allowed the operator to reposition the blades using accurately dimensioned offcuts as spacers. He could then slide the blades into position easily before retightening. Suddenly, the task was cut from 20 minutes to one or two and for timber processors who were into large batch production it was a step forward. But what was a step forward for large batch producers didn't become a giant leap for small batch manufacturers until Weinig

introduced its CNC moving blade technology and RipAssist Pro width optimising software. With the two on a VARIORIP, both time and materials can be saved – and it facilitates board by board production.

With RipAssist Pro, you enter your cutting list for the thickness of board you want to cut – say, 100m x 50mm, 200m x 75mm, etc – and two sensors measure the width of the board automatically, determining the best position for the sawblades to minimise waste. Lasers show exactly where the cuts will be made before the timber enters the machine, so if there is a defect, the blades can be

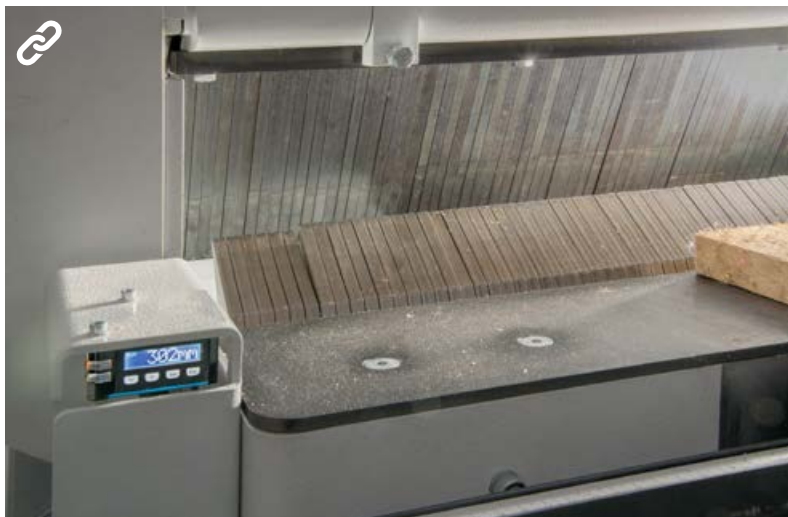


Top left: Two moving blades and several fixed blades is the norm, though you could have four moving blades if you wished.

Left: Laser lights show the exact position of each cut *before* the timber enters the machine.

Bottom left: There are five sets of anti-kickback fingers and a blue Kevlar-type SafetyPlus curtain that traps small dimension splinters on the Variorip.

Bottom right: The unique closed link chain prevents anything getting trapped between the links and spikes on the track grip the timber beneath the pressure rollers so it can't move.



repositioned to avoid it using a toggle on the control panel. The length of the board is automatically measured using an encoder on the track of the Variorip and once it's cut the number of metres of each dimension you need, they are automatically removed from the cutting list and the saw turns its attention to the next item. For bespoke hardwood moulding production, there's nothing to beat it – but what about safety?

Safety is a huge factor in multirips. The blades can nip and fire the wood back towards the operator at the infeed, knots and splinters can get trapped in the chain – some are pretty

evil. In the Variorip there are five sets of anti-kickback fingers and a blue Kevlar-type SafetyPlus curtain that traps small dimension splinters. The chain is also rather special, as the unique closed link design prevents anything getting trapped between the links. There are also spikes on the track that grip the timber beneath the pressure rollers so it can't move. The track design isn't just safer, Weinig say it will also give you around 5-7% better yield. If you're finishing at 45mm, you can cut to 50mm. With a typical bicycle chain transport system that will stretch over time, you'd probably need to cut at 55mm to allow for movement.

Also available from Weinig is an equally time and material-saving cross cut saw that takes the operator right out of the sawing area, making it quite possibly the safest cross cut on the market. The Opticut S50 from Dimter will operate hand in glove with a Variorip 310 and the options available include labelling and transport systems that, with just one operator and seamless software, will take your components from the rip saw, through the cross cut and straight into a moulder. And when it comes to optimisation, the Opticut S50 is quite outstanding.



Below left to right:

Beneath the pusher is a camera that picks up defect markings and a length encoder. The down pressure unit is unique to *Dimter* machines. Options include many time and labour-saving devices.



Take your boards - random or package length - mark any defects with a fluorescent crayon, load the boards onto the machine and press the start button. The pusher lifts up and travels back over the top of the board, measuring the overall length of the board with an encoder and a start-stop light barrier. A camera picks up any marks you've put on the board, evaluates the data and determines the best cutting pattern to minimise waste. The pusher pushes each piece forward so trim cuts can be made, cutting out the defects, and producing the fixed lengths required. While the pusher is processing the first board, the operator is well out of the way and preparing the second. Length precision is reckoned to be around plus or minus 0.1mm.

But the Opticut S50 goes one step further than this: it allows you to assign up to eight

grades and values (real or financial) to each of 999 cutting lists. How does it work? If you have a piece that's a metre long between defects but there is discolouration, it might not make grade A. The Opticut will weigh up whether it's worth taking a 600mm piece of grade A and a 400mm piece of grade B to minimise the waste, or whether it's better taking a one metre piece at grade B according to the value you've assigned to it. It works out what's worth more to you. That's a remarkable feature when you consider even the best among us humans is only good for three grades.

One further time-saving feature is the down pressure unit. This is also unique to *Dimter* machines. If the down holder is, say, 120mm off the bed and you're only cutting 20mm thick components, it has to travel 100mm, clamp the piece ready for the cut,

then travel back 100mm. This is repeated for each cut on a typical cross cut saw. With the *Dimter* system, the down holder establishes the thickness of the first workpiece, clamps, cuts, then moves back only 10mm or so and this feature alone can cut production time down by a good 12%.

To pretty much any of the Opticut models you can add a waste separation system, outfeed tables, cross belt or magazine feeders for even safer one-man operation, conveyors with sorting ejectors that grade, automatic stackers... The list is endless. And on the Opticut there is almost no maintenance – and isn't that a time-saving bonus?

For more information call 01235 557600, visit www.weinig.co.uk or touch any picture with a link sign in the online app edition to watch a video.

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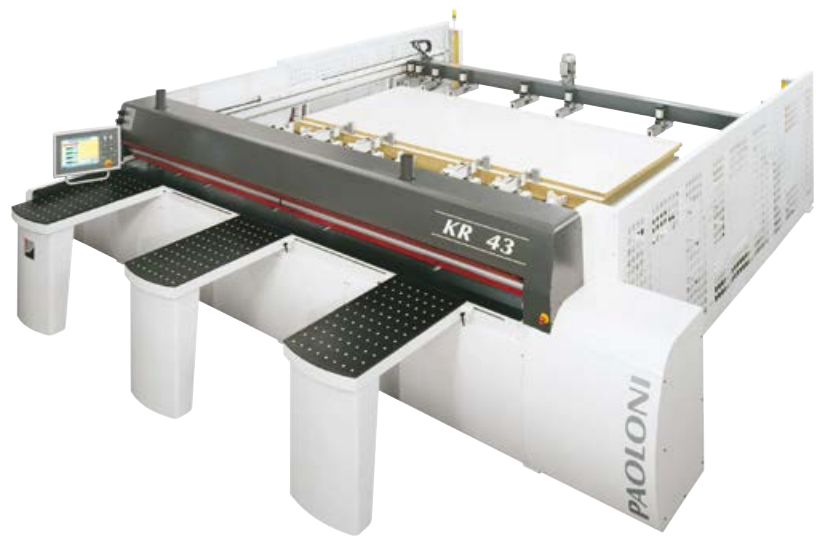
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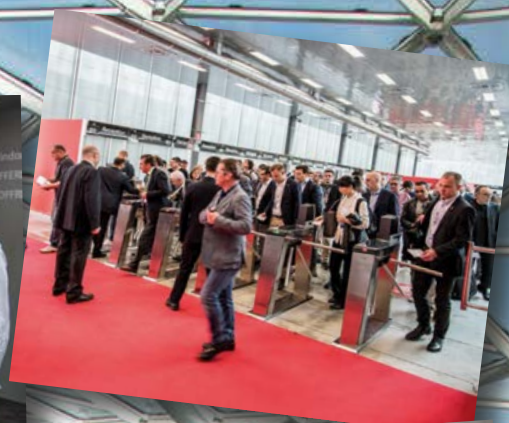
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XYLEXPO
2018



Xylexpo Review

Compact and easy to navigate, Xylexpo proved to be the launch pad for many new technologies.

Occupying four halls of the Fieramilano Rho exhibition grounds and conveniently located at one end close to the metro, Xylexpo 2018, though up a hall on 2016, was never going to compete with Ligna in size, but what it lacked in breadth, this year's edition made up for in quality. The number of innovations and, indeed, new machines and technologies on show made this easy-to-navigate exhibition a worthwhile addition to the visit calendar of anyone shopping around for new equipment between Lignas.

At 17,781, visitor numbers were up on 2016 by around 2.1%. Of those, 5,032 were from outside Italy, and that's broadly the same as 2016, so a lot more needs to be done to

attract foreign visitors to the show. By adding a fourth hall, the organisers increased the floor area of Xylexpo by almost 35,000 square metres since the last edition, enabling the exhibition to accommodate 425 exhibitors. 116 came from outside Italy.

Hall one was dominated by Biesse, hall two by SCM Group, hall three by Homag and hall four, variously by Weinig, Holz-Her, IMA Schelling Group and Felder. In comparison with the Italians, who underlined the growing importance of this event by showcasing many of the new technologies they'd held back at Holz-handwerk, the Germans and Austrians had adopted a lower profile. For them, Xylexpo was clearly more of a flag-wave than a launch pad for the latest innovations. But that left the gate wide open for Italian innovation to shine through. And it did.

In the Xylexpo Innovation Awards, Italian companies took the top prizes in each of

the four categories, *Primary Operation & Solid Wood Processing, Panel Processing, Coating & Finishing* and *Tools*. Particularly well deserved among those were two companies: Vitap, who took first prize in the *Panel Processing* category for its Point K2 Top throughput working centre, a machine capable of producing the left and right sides, the tops and bottoms and the backs of between 80 and 90 cabinets in a single shift; and SCM, who inexplicably didn't receive the first prize but were awarded third prize in the *Coating & Finishing* category for the new planer head for the DMC System sander that is capable of producing a completely textured panel in one pass. You'll find both written up in more detail in the following pages.

If you haven't already made a note in your 2020 diary, the dates to mark up for the next Xylexpo are Monday 25th to Friday 29th May 2020.



Facing Page

Top Left: Finished components are removed with waste material when all processing has been completed.

Top Right: The height of nested components is changed to facilitate edge processing

Bottom Left: The main toolchanger on the P200

Bottom Centre: Subsidiary toolchanger

Bottom Right: There is a clever little valve on the top of each pod that closes the vacuum circuit when it's not in use.

Innovation increases Productivity

In parallel with the launch of its new Maestro Connect app, SCM showed some very interesting hardware that offers production and quality enhancing features.



Federico Ratti

With an impressive 3,000 square metres of stand space, SCM's Xylexpo presentation was by far the largest in Hall Two with some 50 machines drawing huge crowds throughout the show. At the very heart of the stand were demonstrations of SCM's digital tool platform, Maestro Digital Systems, which has been further developed since Holz-Handwerk in March and now includes the brand-new, launched-at-Xylexpo Maestro Connect app. Users with smartphones or tablets will now be able to see when each connected machine is working (and when it's not) in real time. The app provides instant access to a range of key performance indicators with full historical mapping – and alerts you to any abnormalities with a pop up if a machine in your factory strays from benchmark performance data or develops a fault, so you can take immediate action remotely.

At this year's Xylexpo, however, the focus for Furniture Journal was not so much on SCM's Maestro software, which we reported on in detail in the May edition (see pages 32-35), as some very interesting hardware that

offers production and quality enhancing features. Two Morbidelli's took centre stage:

The Morbidelli P200 machining centre for drilling, routing and edgebanding may not be new – in fact, it was launched at Ligna 2017 – but it's a machine that's evolved, come of age and now, thanks in part to its unique, patented High Efficiency pod system and clever Maestro software, it facilitates some very tangible time and material savings for panel processors. So, what's special about it? Imagine, for example, that you're making curved desk tops. Normally, you'd roughly size your full panel on a saw, transfer it to a router, machine the curved shape, then transfer it to an edgebander to edge and finish it – and, typically, you could expect something up to 20% of the full panel might go to waste. Using the Morbidelli P200, although it's a relatively compact footprint machine, your panel can be loaded onto the bed, nested to give the best possible yield (or more usable offcuts), and the desktops can be routed and edgebanded without any transfers, all on the one machine. The nesting process alone will take your waste right down – possibly to as little as 5% -



and not having to transfer the components from one machine to another could save you 30-40% in time. Very neat.

But how does it manage to edgeband two nested components without removing one from the machine? Well, the key is a very clever rising and falling High Efficiency pod system: "If you want two different parts from a panel, both finished, a machine can cut both easily, but the problem for the edgebanding unit is always the space between the two parts," Federico Ratti, SCM's Technical Director, explains. "Normally, you can move them horizontally to increase the distance between the parts. With the Morbidelli P200, the dimension of the table is the same as the parts but the vacuum cups move up in order to raise the first cut part above the level of the second so it can be edged all the way around. Then the cups swap over, allowing those under the second component to raise the next panel above the finished panel so it can also be edged. With the first component out of the way, the second can be edged easily. Many parts can be processed at once in this way."

With this relatively small machine – and the P200 takes up far less space than a saw, a router and an edgebander – you can work a full-size panel. It's equipped with the latest safety system that provides access around the machine without fencing, reducing further the space it takes in your factory, and it makes a complete piece without any loading and unloading during processing. Certainly, straight edgebanding can be done more efficiently on an edgebander but SCM maintains the cycle time would be higher because of the loading and offloading time.

"It's all about cycle times," adds Filippo Romani, SCM's Product Area Manager responsible for CNC and drilling machines in Poland and North America. "With the table on the Morbidelli P200, we can create multiple shapes without pre-sizing. You place a big panel on the table – up to 5' wide, 12' long and 80mm thick – and the machine will nest them and cut multiple parts, saving all the time you'd use for pre-cutting and simultaneously reducing the waste material. The software raises each cut part (one at a time) to complete the job, drilling, edgebanding,

trimming and scraping as necessary. The operation is seamless, without changing tools, and that also reduces the overall cycle time. There are various edgebanding, routing and boring solutions but it's the independence of the table that really makes this machine unique – horizontal machining, drilling and edgebanding can all be carried out on surfaces that would otherwise be inaccessible."

Removal of offcuts is another area where the Morbidelli scores because the waste



Filippo Romani

doesn't need to be removed during the processing cycle. "There's no need to stop the machine," says Filippo. "Offcuts sit on the bed, out of the way of any machining process until the components are ready to be removed."

A typical configuration would see the P200 equipped with two edgebanding coils for 85mm x 3mm tapes, though it can be equipped with an additional coil changer that will take six more coils and effect changeovers in hidden time. Switching over from EVA to PUR, or coloured to clear, is a simple process of unplugging two cables, turning two screws and swapping the glue pot for a different one that's kept ready on an external glue station. Switching glue pots is a minute's job for any skilled operator if the need arises to process a couple of dozen bespoke panels midway through a production run.

If you don't need the edgebanding facility, however, you could still save processing and transfer time by equipping the Morbidelli for horizontal and vertical drilling operations. Once the nest has been created by the software, all the operator has to do is press the start button. The pods operate automatically and when not in use, to save vacuum, there is a clever little valve on the top of each that closes the vacuum circuit.

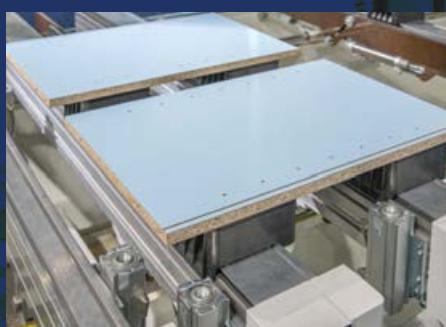
Another machining centre that really deserves mention is the 'new concept' Morbidelli M220 for drilling and routing furniture panels. This machine will process various panels simultaneously. Introduced in Rimini in January 2018 but shown for the first time at Xylexpo, the M220 offers time savings of up to 70% compared with traditional machining centres. Equipped with two parallel, independent drilling heads that are controlled with Maestro software, it will optimise the machining operation and determine the fastest possible drilling strategy automatically and without any operator intervention. The software applies an algorithm that determines whether the drilling heads should be used independently with one head working each panel, or whether it would be more time efficient to use both heads simultaneously on one panel – and any shape of workpieces can be created in just a few clicks.

"Productivity also increases because head one can work while head two changes the tools and vice versa," says Federico Ratti. "The M220 can be equipped to suit exactly what the customer wants to do. Typically, the head has one or two spindles and a boring head but there are three and five-axis options. You could have one head of each type, one five-axis with a boring head, or just boring heads if you wanted increased drilling throughput to get rid



Left: Typically, the head has one or two spindles and a boring head but there are three and five-axis options.

Below: The drilling heads can be used independently with one head working each panel, or with both heads working simultaneously on one panel.

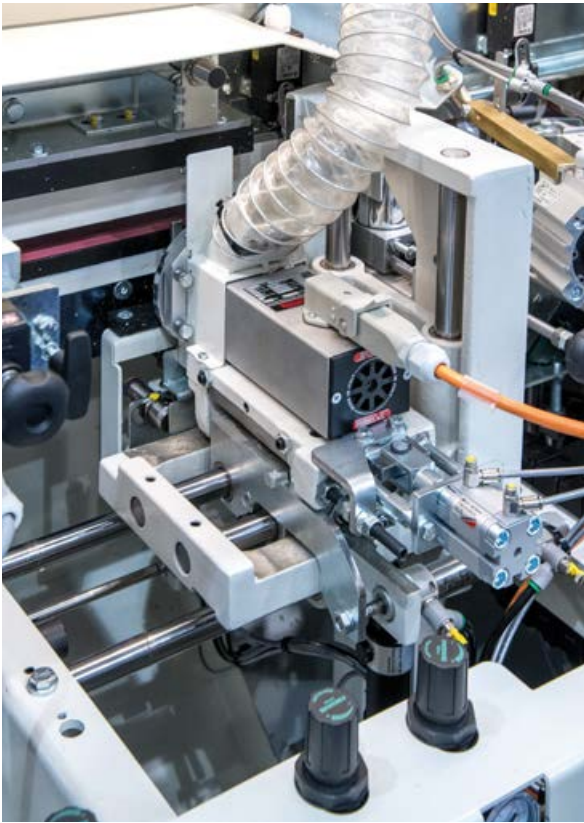


of a bottle neck. Because you have two CNC heads, you can have nesting and drilling on the same machine, overcoming the problem that drilling is very slow."

"The same type of panel, or left and right panels, or top and bottom panels can be machined at the same time on the M220," adds Filippo Romani. "Or you could optimise a single panel using both drilling units at the same time. It's otherwise a regular CNC and we have lots of different options, such as air or liquid cooled, that can be specified. It's possible

to keep up to 60 tools on the machine for big performance in drilling and routing. The frame is the same as the P200, so it's rigid enough for both types of operation."

If you'd like a demonstration of your product being produced on either of the Morbidelli machines featured, call SCM on 0115 977 0044, or download the free Furniture Journal app and touch pictures marked with a link sign for an immediate link to video demonstrations and more. Alternatively, touch info@scmgroupp.com to send an email.



The new group (left) has been designed with best quality in mind

New for Xylexpo and part of the Minimax range, was the SCM ME35 edgebander, equipped with the new combined corner-rounding/end-cutting unit, presented as a world première. This new feature won the 1st prize in the Xylexpo Innovation Awards. The award commission was impressed with its ability to “combine edge-rounding and end-cutting features in a single tool, allowing compact-sized machines with a minimal footprint to be developed”. The technology makes this edgebanding machine a must-have product for small-sized joinery businesses - the ideal one-stop machine for end-cutting the front and rear ends of panels and, at the same time, rounding the front and back edges.

“Its performance in terms of quality is near to an industrial machine,” Federico Ratti told Furniture Journal. “With great flexibility, it applies melamine edges, PVC and ABS up to 3 mm and works small panels with a length starting from 120 mm and thickness from 8 mm to 50 mm. With this machine, the small joinery can work the full range of panels for kitchen, living room or bedroom furniture and the quality of edge finish is exceptional.”

With the launch of the new planer head for the DMC System sander at Xylexpo, it's now possible to completely texturise a panel in one pass (and in just a few minutes) instead of laboriously producing the effect with a CNC machining centre. Using two heads, both of which move from side to side and vertically up and down, the DMC System is simple to operate and allows you many different texturing or patterning. All movements are controlled by CNC and the texture is input from a drawing you build on screen. The DMC System will even create a random movement to produce waves, or a pattern that flows seamlessly from one panel to the next in a set. It's perfect for wall panelling in large areas and there are as many patterns and block designs as are possible. Where once you needed multiple passes, or multiple heads on a CNC, now the pattern you want can be created quickly and easily in one pass – on a sanding machine. Touch the picture and watch the video. Brilliant!

Inside the DMC System, showing the new planer head



Industrial quality corner rounding from an entry level machine.





Over (and above) the Finishing Line

The art of finishing encompasses many specialist areas that SCM Group has gathered together in order to offer complete solutions.

What comes to mind when you think of the name Superfici? Spraying machines? What about Elmag? Drying and curing technology, maybe? And Valtorta? Roller coaters? Since the three became part of the SCM Group, that's certainly part of the story - but only a small part of it.

For a number of years, SCM Group has been pursuing a policy of acquisition that enables it to offer customers a broad spectrum of related technologies and solve a wide range of problems by drawing on specialist cross-industry experience amassed over decades. One of the technology areas that's benefited hugely from the SCM business model could be broadly termed finishing, and pivotal to SCM Group's success in this sector were the acquisition of both Elmag and Superfici. But on a tour of the new Elmag Superfici factory in Monza, acquired in January 2018, it became clear there's a lot more that customers can gain from working with Elmag Superfici than just

buying spraying and curing technology. Gabriele De Col, Managing Director of SCM in the UK, explains:

"The business model SCM has been pushing towards for the last few years has been better integration of technologies for the finishing of the surface. Here, at the Elmag Superfici Technology Centre, we have technology that encompasses every aspect of finishing from preparation of the surface using DMC machinery, to the application and curing of the paint with Elmag Superfici technology. We can also look outside the Group for even more specialised finishing to companies that produce, for example, special brushes, or have particular expertise in the printing of surfaces. We have the facility to integrate digital printing within a line and the technology available to print wood, plastic, composite, stone and many more materials.

"These days we are finding more and more customers want something unique, something different that gives them product differentiation. We can support that by

 The Compact 3 is an ideal first step for automated spraying



putting our skills together under one roof, trialling and testing application and production methods until we achieve the result the customer wants. When customers come to Monza, they can pass panels through our machines, touch the results, spray them in a machine and cure them so they can be sure the result of the whole process matches exactly what they want to achieve.”

In many respects, finishing has always been a bit of a black art. Certainly, it’s a combination of technology and art that involves a certain amount of experimentation. Getting the combination right isn’t generally something most manufacturers have time to break away from production to play with. That’s where Elmag Superfici can shoulder the load and try out different materials, application methods ranging from roller coating to spraying, and various curing systems. According to the type of pigment and paint that’s required to achieve the finish you want, Elmag Superfici provides access to various curing technologies from hot air,

infra-red and microwave to cold curing with LEDs. “Hot air is limited by the need for long tunnels,” says Gabriele, “And not all companies have the space, so not only do we take into consideration the product the customer wants to produce – and his budget – we also customise our offer so it works within the physical constraints of the factory space available.”

To illustrate the breadth of technology available, a full custom-designed 130-metre line was being readied for demonstration to its eventual owner at one side of the Elmag Superfici factory, while not 30 metres away was a production line where each of the 20 or so stand-alone machines destined for smaller workshops was being assembled and customised. A short distance away – under the same roof – the Technology Centre bristled with DMC sanders equipped with different brushes, pads and sanding units; several Valtorta roller coaters; various curing systems and robotic sprayers. And in the midst of the demonstration area, engineers



Gabriele De Col

Engineers,
heavily involved
in a discussion.



The Technology Centre includes DMC sanders, several Valtorta roller coaters and various curing systems and robotic sprayers.



were heavily involved in an intense discussion about adapting and redesigning part of a machine to work with some very specific materials a customer wanted to use.

"Elmag's experience in the automotive sector provides access to highly specialised finishes," explains Gabriele, translating part of the discussion. "Inside the Technology Centre, we often work with materials that have come from other industries. Some are not even paints. The headlamps of cars are not glass any more but they must not scratch. This involves the application of a film that hardens like glass. It's applied with our equipment. The precision required is much higher than anything needed by the furniture industry. Working with many different

industries brings new requests to the market and, where customers need something unique, it enables us to provide the experience necessary to satisfy even quite specialised enquiries from the furniture sector. It's also led to the development of completely new technologies."

Elmag Superfici was in the front line of developing LED-curing technology. At Xylexpo, the company showed another new development – Vacuum Ultra Violet curing, or VUV – and in the race for the ultimate supermatt paint finish, VUV seems to be at the top of the game. "Spraying paints to achieve a matt finish often gives quite a coarse result," says Gabriele. "What's been achieved by Elmag Superfici, however, is a level of matte that is

close to zero; a really pleasant, silky, soft finish that doesn't scratch. It's the result of special polymers in the paint that are applied in an inert environment and the use of special lamps in the curing process." I confess, it is unlike any supermatt paint finish I've come across before: very impressive to say it's applied directly without any post-finishing.

If you're on the point of concluding Elmag Superfici is a company that's only appropriate to large scale manufacturers who need big lines, or those wanting something rather special, don't turn the page just yet. Even the smallest workshop – the one who can't find the necessary skills to continue hand spraying – will find something of interest in Elmag Superfici's portfolio. "For the smaller company,



A 130-metre line being prepared for customer demonstration.



we have a range of machines that start from a very basic booth for companies that need to move from manual to automatic spraying, and these units don't cost hundreds of thousands," says Gabriele. "We showed a small machine at WI16 and we will present another model at the next W Exhibition. If you have 10-12 square metres of space, that's all it takes and the benefit is a consistent finish. You can have a self-cleaning gun system and we offer a choice of different recovery systems according to whether your work is small batches, or large batches. The machines themselves need very little maintenance beyond cleaning. They are very simple. The software always ensures correct dosing and the machines are built to withstand millions of cycles.

"Smaller companies often need custom solutions tailored to their pocket and we try to optimise this, too, using the customers preferred suppliers of guns if they have a relationship with a particular local supplier. We can cater for the larger user who wants a complete line right through to the smaller workshop."

For more information on Elmag Superfici products, or to discuss a particular finishing problem, contact SCM in the UK on 0115 977 0044, or download the free Furniture Journal app and touch any of the pictures in this article for an immediate link to video demonstrations and more. Alternatively, touch info@scmgroup.com to send an email.



Gloria Valtorta,
Sales Director for Elmag Superfici

"Elmag Superfici is quite unique in the world of finishing. We can demonstrate sanding, spraying, finishing and curing, all under one roof and supply a single machine or a complete line. Within the company we have access to many specialist technologies and we are developing new technologies all the time.

"Recently, we have developed a new UV LED curing technology that has the advantage of being a cold process. Without heat applied to the surface, it opens the possibility to apply coatings to thermo-sensitive materials. Digital printing is also coming into our world and we can integrate this into complete lines, too.

"Elmag Superfici supplies complete solutions that are customised to either large customers or smaller customers. Our Technology Centre is open to anyone who wants to experiment with materials and lacquer to find the best solution for their company. We can combine our knowledge with experience from other companies in the SCM Group, such as sanding, special finishes made by carving systems, or membrane pressing. This is ideal for the increasing number of customers who want to diversify their products and create differentiation by using special effects, or different materials.

"Some of the more unusual applications we have been involved with include finishing house tiles with a snow effect and a green lichen effect for one client. Customers have brought us many different materials to work with from wood and glass to glassfibre and cement. We can achieve almost any effect, and here, in the Technology Centre, we can simulate the entire process to demonstrate the solutions we offer."

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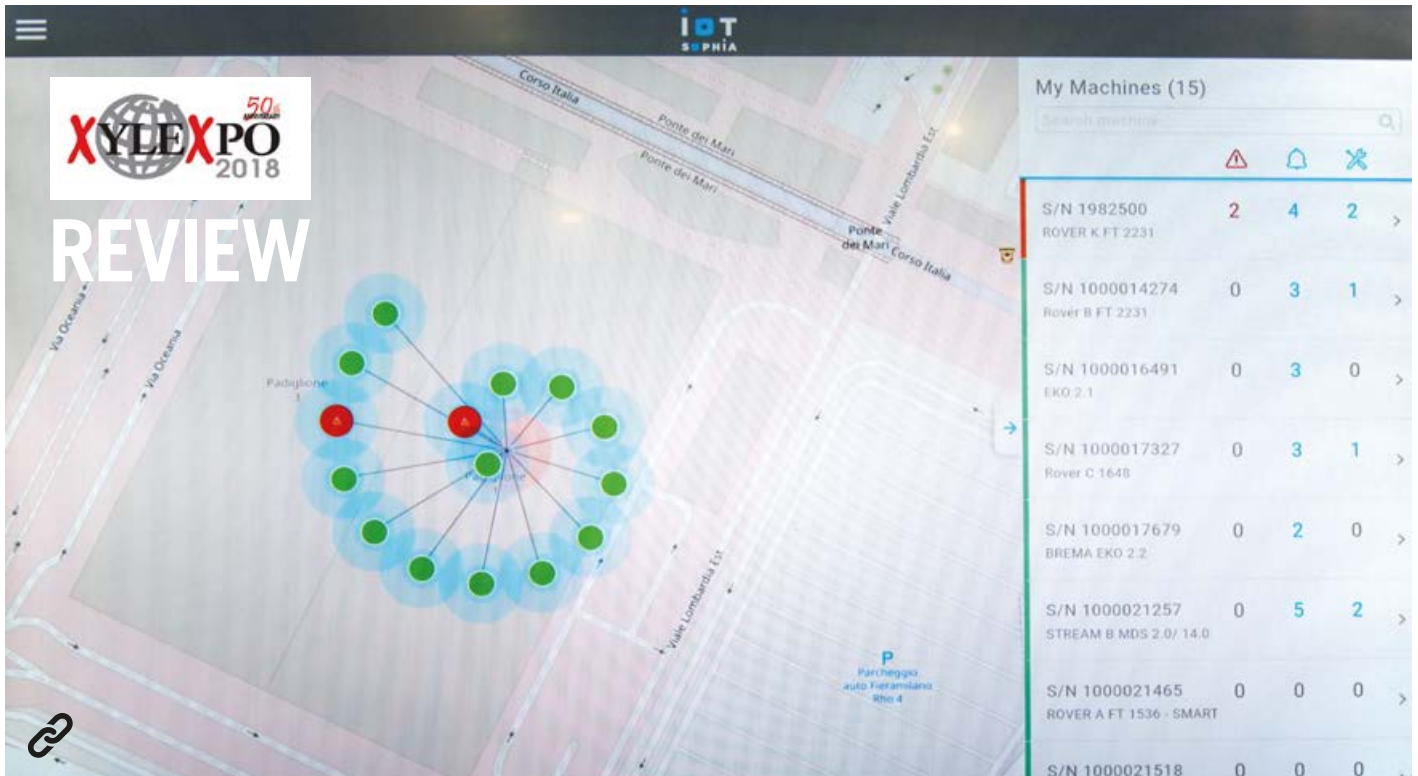


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SOPHIA: the app

We've probably all had a sneaky peek at the astrology column in the paper to see what's in store for us at one time or other – and more than likely smiled and put it to one side because it's too generalised, or simply too unbelievable to be taken seriously. I've never yet read anything that told me, *Hey Scorpio, your hard drive will go down in the next seven days. You'd better do a backup and contact the Apple shop pronto.* Unfortunately, Biesse doesn't make a version of its incredible SOPHIA IoT solution for Apple users, otherwise that's exactly what it would do – and a lot more besides.

SOPHIA is far more scientific than astrology in how it works out, predicts and takes action to help prevent breakdowns and interruptions to your production, as Andreas Basghini explained from Biesse's Xylexpo stand: "Biesse's digital hub currently contains SOPHIA IoT and SOPHIA parts," he explained. "It's a development of the IoT platform that was created together with Accenture, but with new functionality. It includes the collection of data from machines, which is sent to the cloud, and that provides information both to Biesse and to the user. The SOPHIA IoT mobile app allows customers to monitor data on the status of the machine from their smartphone or tablet and to request assistance from Biesse

service if it's needed. But it goes much further than that.

"SOPHIA offers different functions, such as a daily report that provides three standard key performance indicators – efficiency, effectiveness and availability. These elements together constitute OEE (Overall Equipment Effectiveness), the measure of the performance for the machine. Then we have a report for a full week and that offers the opportunity to look at the three key performance indicators for any selected day. By collecting data and running it through a learning algorithm, SOPHIA is also able to predict when a component is likely to fail and it will send this both to the user and to Biesse engineers. Biesse Service can then contact the customer to establish whether he has noticed the messages from the app and discuss the issue and what the customer may wish to do about it.

"SOPHIA also sends a notification to any app user when the machine stops. The information is collected, analysed and provided to the customer to bring the stoppage to his attention. In addition to alarms, the mobile app sends push notifications directly to the user relating to maintenance tasks that might need to be performed by the operator, or parts that might need to be changed. For example, if there is no more glue available to the machine,

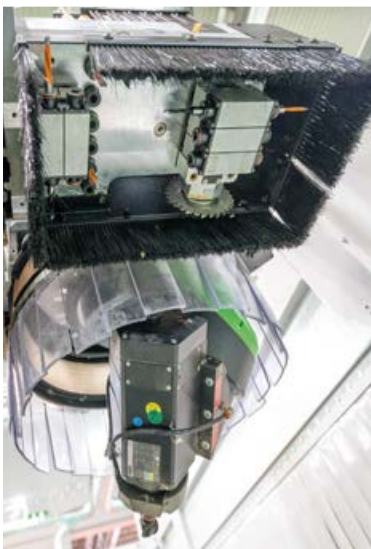
Biesse's IoT solution, SOPHIA, is now available for smartphone and tablet users.



Andreas Basghini



S/N	ID	Description	Date	Status
1982500	9004_100	Inverter Emergency	09/05/2018 11:45	ACKNOWLEDGED
1000021357	17_200	RH GLUE SCRAPER LIQUID TANK LEVEL CHECK	08/05/2018 18:04	ACKNOWLEDGED
1982500	90054_100	Scheduled maintenance: maintenance operations on the boring machine are	08/05/2018 17:07	ACKNOWLEDGED
1982500	9282_100	Electrical cabinet overload cabout KO	08/05/2018 16:03	ACKNOWLEDGED
1000021831	90053_100	Scheduled maintenance: maintenance operations on the vacuum pump are	08/05/2018 11:55	ACKNOWLEDGED
1000014274	90057_100	Number of remaining labels lower than minimum value. Replace the roll and reset	07/05/2018 18:20	OPEN
1000023116	23_200	Machine in emergency	07/05/2018 18:20	OPEN
1000023170	13_200	RH CORNER ROUNDER LUBRIF. GUIDE SLIDE BLOCKS	07/05/2018 18:20	OPEN
1000017327	9101_100	System Lubricant Non Present	07/05/2018 18:20	OPEN
1000021465	9965_100	No pieces in the Nesting Cell loader	07/05/2018 18:20	OPEN
1000016491	9002_100	Lubricate the spindles that have the manual system	07/05/2018 18:20	OPEN
1000023292	8715_300	Antivirus updating	07/05/2018 18:20	OPEN
1000022168	8707_300	Cleaning the cutting axis inner part	07/05/2018 18:20	OPEN



a notification is sent that it needs replenishing. The SOPHIA IoT app will also send notifications to Biesse to request availability of a spare part, so when it becomes necessary to change this, the part is available and the task can be performed quickly at a time that suits the user of the machine.”

Rather cleverly, within the SOPHIA mobile app there is a facility to conduct a video session. “When something goes wrong, the customer can contact Biesse service – or the other way around – in order to start a video session through the mobile app and, using either an iPhone or an iPad, the customer can show to the engineer what is happening,” says Andreas. “The operator can take photographs, or videos, or a screen shot and these can be shared with an engineer in order to arrive at a quick resolution. There is no need for the customer to have any additional equipment other than the smartphone or the tablet that the app is installed on.”

The only requirement for the machine is that it must be IoT ready. All new Biesse machines are IoT ready, but with the addition of

an additional piece of software, or in some cases just an update, many older Biesse machines can also be connected and could benefit from the app. Carrying out a check to see if your existing Biesse machine has the necessary functionality is a relatively straightforward task.

So how much does the app cost? The app itself is a free tool and the first year’s machine connection to the SOPHIA platform is also included in the sale of the machine. Performance analysis of the machine is collected over the year, including any stoppages, which can then be discussed in detail with the customer. This gives Biesse engineers the opportunity to provide suggestions that might further help production, or reduce maintenance. At this point a new service agreement can then be discussed.

Ultimately, the more Biesse users who sign up to SOPHIA, the greater the benefits for both present and future Biesse machine users will be. For present users, there is functionality that will help in detecting potential malfunctions and assisting customers in maintenance operations, as well as ordering

replacement parts, ultimately helping to improve the up-time of their machines.

Over the past five months connected machines have registered a 60% growth in productivity and the platform has highlighted that Biesse has handled more than 2,000,000 events of various types.

In the long term, however, continuous monitoring and collection of data from thousands of machines around the world will provide a valuable library of information that will allow Biesse to keep a check on all the key components within a machine and modify designs to further improve performance. It can also play a major part in the improvement of productivity and reduction of inefficiencies.

If you’d like to know what’s in store for your existing Biesse machine, or you are thinking of buying a new machine and would like to know more about SOPHIA, call Biesse UK on 01327 300366 or email info@biesse.co.uk. You can watch the SOPHIA presentation on video by downloading the free Furniture Journal app and tapping the image with a link sign and the email address links directly with Biesse UK.

SOPHIA

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Made in Minutes

Five piece doors, ready for assembly in under three minutes, and fully inserted top and bottom panels: easy with a Stema Tabit.

If you're making your own five piece doors and finding it a bit of a chore, or if you are buying five piece doors in and would prefer the flexibility and choice that comes with making your own, it's probably the right time to take a closer look at a Tabit machine from Stema.

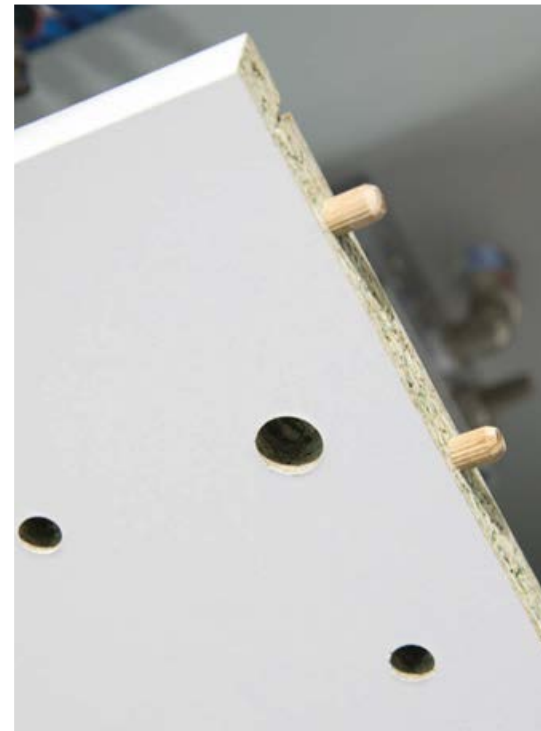
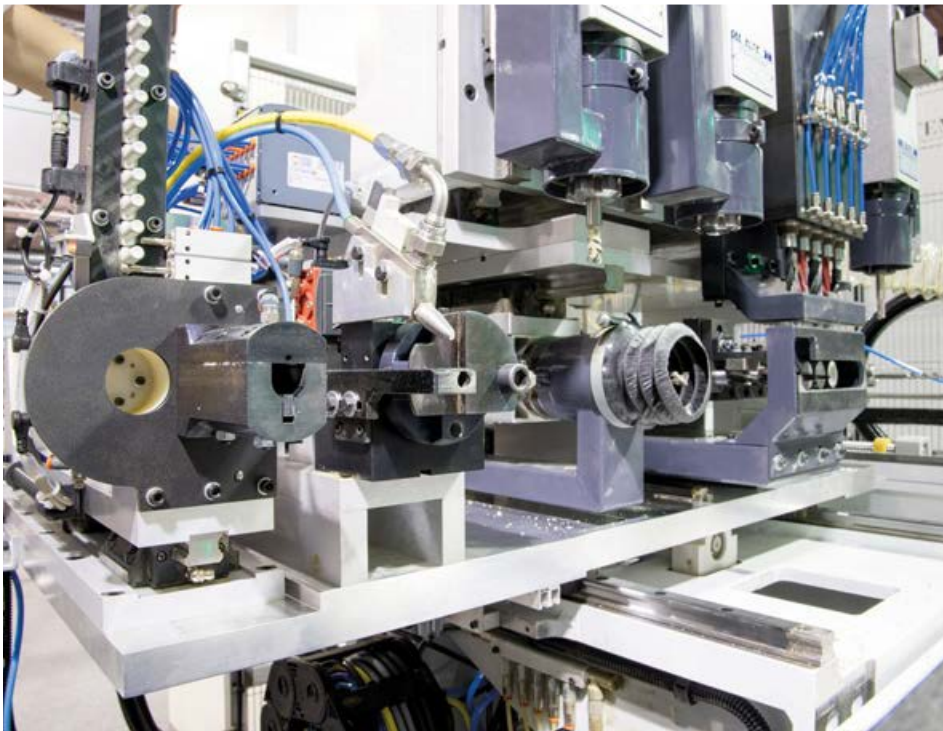
Represented in the UK by RW Machines of Bicester, Stema designs and builds Tabit machines like the one shown at Xylexpo to order so they do exactly what you want them to do. Broadly speaking, that could be anything from drilling, gluing and dowelling the stiles and rails for a drawer front or a large wardrobe door to producing entire carcasses including

shelves, top and bottom panels and equipping them with fixings ready for assembly.

"A Tabit will produce doors of 240mm long up to 2.4 metres for wardrobes," Stema's MD, Eugenio Cicardi told Furniture Journal from the Xylexpo stand. "And it will make drawer fronts with stiles and rails of 40mm or more. It takes only two and a half minutes to make the four frame components on a Tabit, and it can be equipped with a 45-degree unit in the central area of the machine so it can work 45-degree edges as well as 90-degree doors.

"We have no standard machines. All Stema machines are built to order and equipped so

XYLEXPO 50th ANNIVERSARY
2018
REVIEW



they do exactly what is needed. Some factories only require door production, others want doors and horizontal parts of carcasses. That's what the machine on our stand is equipped to do."

The Tabit on show had been equipped with a horizontal drilling group comprising five independent spindles and adjustable rotation speed up to 4,500rpm that would enable panels of up to 55mm in thickness (in the Y axis) to be worked. There were a further five spindles in the vertical drilling group. Vertical routing was possible from 0-160mm into the panel face using the three routing groups (RH+RH+LH) and there was a

separate horizontal routing unit (RH). Specific to this machine was a 1300mm long bit drilling unit. The grooving saw was powered by a 4kW motor, while the routing units used a 2.2kW motor.

Stema's Tabit can be equipped to insert various different fixings. On the machine at Xylexpo, there was an insertion unit for dowels and a separate inserting unit for spring-type shelf supports.

"Lead time for a custom built Tabit is typically around 150 days," says Eugenio, "Though it can be several months more if we need to produce a line. If you need special insertion, for example, or some other

modification to suit your production, it has to pass through technical offices to get the necessary safety certificates and documentation, and that alone takes around four weeks. Each machine has to pass this because our machines are not standard. They are all custom built."

For more information on what a Stema machine could do for you, contact RW Machines on 01869 244943, visit rw-machines.co.uk or, if you have downloaded the free Furniture Journal app, tap sales@rwmachines.co.uk to send an email. A YouTube video of a Tabit in action is available by tapping the picture above marked a link sign.



REVIEW

Drum Roll for Kleiberit



Kleiberit launches a new profile wrapping adhesive that will appeal to manufacturers servicing the most cost-conscious sectors of the profile wrapping market.

If you are wrapping wood-based profiles – anything from MDF to pine – with paper, vinyl, or decorative materials, you need to know about a brand-new development from Kleiberit that can help you cut costs as well as maintaining your product quality, even with difficult-to-wrap materials and challenging profiles.

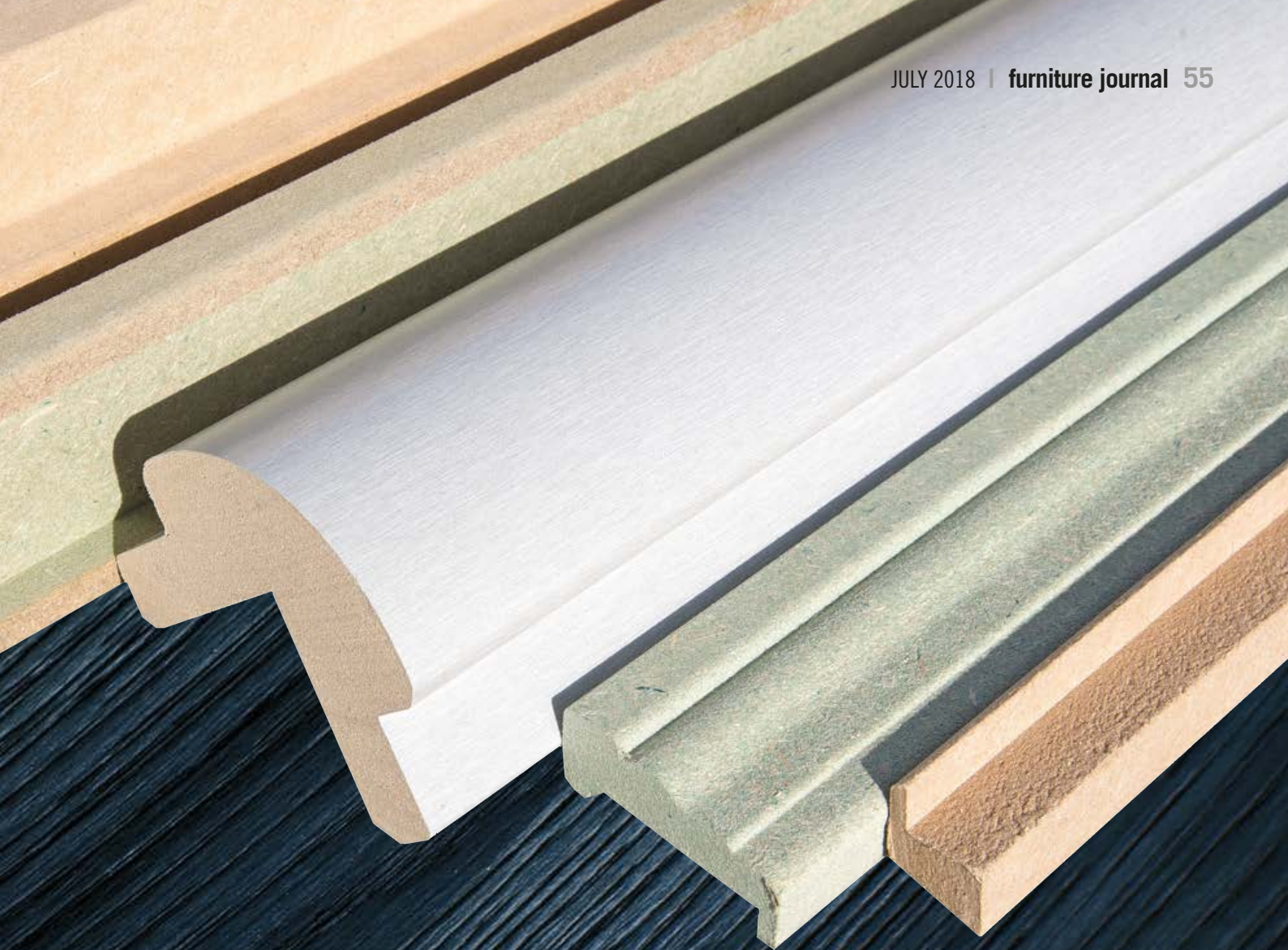
PUR HM Kleiberit 702 range of profile wrapping adhesives is well proven and for several years, 702.5 in particular has been a core product for manufacturers from around the world working with anything from architraves to skirtings and profiles used in kitchens. The 702 range includes viscosity grades for demanding materials that are perfect for more delicate materials with a very low softening point, or vinyls with a low overall thickness that can easily stretch during manufacturing. But with its new 702.8 grade, launched at Holz-Handwerk/Germany and

promoted strongly on the stand at Xylexpo in Italy, Kleiberit has come up with a winning formula that will really appeal to those servicing the most cost-conscious sectors of the profiles market.

“We have just released a new product called 702.8.08,” commented Kleiberit’s Wolfgang Hormuth. “It’s a new PUR HM adhesive which has very good processing characteristics that works well with many materials like paper, PVC and other foils. This product has good application characteristics at a very attractive price, but we’ve managed to achieve that without any reduction in the performance of the product. It has been run through industrial processes and has performed extremely well from high gloss foil wrapping up to veneer wrapping.

“In the past, we have always offered different products for foil, paper and veneer. The new 702.8.08 product will work with





many types of substrates and works on wrapping machinery from single profile wrapping machines to complete surface lamination lines that are equipped with slot nozzle technology."

Aside from the attractive price, the key advantages you'll benefit from with Kleiberit 702.8.08 include a very high green strength with pronounced tackiness, heat resistance to over 150 degrees Celsius and cold resistance down to -40 degrees.

"The 702.8.08 product is also sustainable," adds Bradly Larkan, Kleiberit's General Manager for the UK, Ireland and South Africa. "The supply chain, availability of raw materials and our stock holding around the world means everything is geared for customer satisfaction, allowing us to meet the requirements of the marketplace whilst offering manufacturers an economical, cost-effective option. We pride ourselves on being

able to offer a specific technical product offering and this product is no exception.

"Every market is looking for a product that performs at the highest level for the decorative materials they are wrapping. However, in the UK, most manufacturers want to achieve standards set by the FIRA Institute. In order for us to fully service this market, the new 702.8.08 range complies with the test methods used to meet the requirements set by FIRA."

Like the other products in the 702 range, Kleiberit's 702.8.08 is available in 1.8kg, 20kg and 190kg packaging options and is already available for immediate delivery from Kleiberit's Coalville warehouse. To place your order, or for more technical information, contact Kleiberit UK on 01530 836699, or if you are reading the free, interactive online edition of Furniture Journal, touch the picture for an immediate link to more information on Kleiberit's entire range of PUR hotmelts.





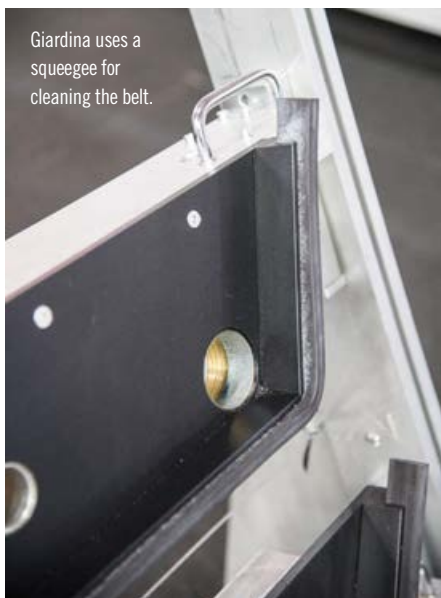
REVIEW

The Dualtech 415 is a dual arm, reciprocating machine with 1880 mm between the arms, ball recirculation guides and brushless motors.



Advantage Giardina

Giardina showcases its new Dualtech 415 sprayer among a range of coating equipment at Xylexpo.



Giardina uses a squeegee for cleaning the belt.

Xylexpo provided a real showcase opportunity for the spray and coating specialist, Giardina. For larger manufacturers, the company was running live tests with no fewer than eight different paint manufacturers, demonstrating a full range of priming, base coating, top coating, high gloss and flat matt finishes for profiles and panels.

For smaller workshops that have reached saturation point with their hand spray operations, or are subcontracting and want to bring it back in house, Giardina also showed its latest stand-alone profile sprayer. A panel spray machine that's ideal for priming and base coating, the Dualtech 415 is available in self-cleaning and paper belt options, enabling full recovery of overspray – and here, Giardina is quite different to other manufacturers. Giardina machines don't use a scraper system, they use rubber squeegees. The paint removes the paint off the belt so when it comes up on the infeed it's clean, dry and no contaminant. Using a rubber squeegee against the belt prevents the surface of the belt from getting scratched, increasing longevity.

The air input on the Giardina 415 is prefiltered, reducing contamination and making it easy to spray flat matt or high gloss. The air pressure is controlled and variable. Cleaning is easy, too, because there is no full cleaning station to pull out, just a tray that you remove a squeegee from. The plate that holds the guns on the Dualtech has a quick release mount that enables all four guns to be removed for cleaning in one go. A proper end-of-day clean down takes about ten minutes.

With the Dualtech 415, Giardina has also solved one of the most difficult problems in spray painting: the j-pull handle. Without the use of any robots, the reciprocator alone is sufficient to provide a perfect coating inside and out, and because workpieces of up to 80mm can be coated in one pass, out-of-the-norm components, such as staircase newel posts, can also be coated easily.

Giardina is sold through Schuberts in the UK. For more information, or for a complete package including painting and drying, call 01226 360900 or visit www.schuberts.co.uk



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KLEIBERIT Adhesives UK

Max Becker Drive, Unit 3 Brunel Way

Stephenson Ind. Est., Coalville • Leicestershire LE67 3HF

Phone: +44 1530 836699 • Fax: +44 1530 836677

Email: uksales@kleiberit.com

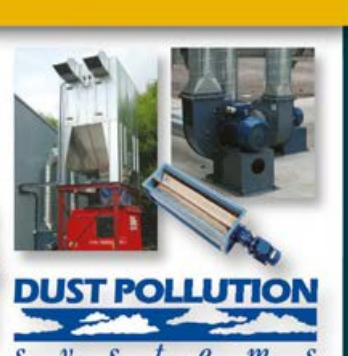


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Four-Minute Magic

Simplicity, speed, safety, accuracy, flexibility, convenience – when you look down the list of attributes to Vitap's Point K2 Top throughfeed working centre, the new contender in the cabinet production market has a lot going for it. Capable of producing both the left and right sides, the tops and bottoms as well as the backs of between 80 and 90 cabinets in a single shift, the new Vitap Point K2 Top made its debut at AWFS in Las Vegas last year (it was a finalist in the AWFS Visionary New Machine Award) and helped the company win a coveted XIA Xylexpo Innovation Award for the best innovation in panel processing.

"More customers want to make customised specials," Franco Tanzini, Vitap's Product Sales and Production Director, told Furniture Journal from the company's Xylexpo stand. "With this machine, it is very easy. You can have a stock of rip cuts – 60cm rips, 40cm rips, whatever widths you need. You enter these in the program and the machine will cut and work all the parts of a cabinet, including the back. You then crosscut those, drill,

crosscut, drill crosscut, etc. It is a true batch size one machine in a compact format – a fully automatic boring machine with through panel drilling from below and automatic return of the piece to the operator with either front or rear panel discharge.

"The Point K2 Top is very productive. With this machine, you can make 80-90 cabinets a day in an eight-hour shift. It's absolutely affordable – a low end CNC machine price – and you can also square pieces, like in nesting. While the machine is making the four pieces, the operator can edgeband them and assemble them. We can say that, roughly speaking, every four minutes a cabinet comes out of the machine, already assembled. If you have multiple cells like this with an edgebander, it will substitute the router, the saw, the drilling machine and the profiling machine."

The Vitap Point K2 Top is a throughfeed working centre that makes vertical and horizontal drilling, routing and grooving possible in one pass, without operator intervention. It has a fairly typical Y and Z axis (1200mm in the

The award-winning Point K2 Top from Vitap will enable you to make 80-90 cabinets a day in an eight-hour shift.





Vertical and horizontal drilling, routing and boring from below.



Both front and rear discharge of the panel are possible.

Y axis), but the unusual feature of the Point K2 Top is its Double Dynamic Transport system, or DDT, that works with components of up to 3700mm in length. "There are two clamps and both move with DDT," explained Franco. "Normally, clamps move one by one in a short axis. With our specially developed software, these clamps work together and never stop the piece while it is being machined. This is vital while you are routing or grooving because if the cutter stops in one place it can leave machining marks in the piece. It's the double clamp technology that enables the machine to complete the machining of the four sides of the panel and of the lower face in a single process,

without any intermediate intervention or set-up by the operator – but it also enables sink or other cut-outs to be machined in worktops.

"One of the main advantages of this system is you can do Bar Nesting – it's one of five patents we have on this machine and it enables complete panel machining. Normally, you nest a big board, put it on a flat table machine and you cut and make operations on the single pieces. The disadvantage of classical nesting is you generally need to use big boards when in reality you might only need half a board, or a third of it. Also, with most nesting machines you cannot make any horizontal drilling. This machine will use small panels, even part panels or spare

pieces, and it performs every single operation with no setup. It is what we call a combined machine for all-in-one making of panels."

The Vitap Point K2 Top is an ideal solution for small and medium-sized companies with limited budgets and reduced storage capacity, as well as for larger companies that need a lower cost, high productivity CNC machine.

Vitap is represented in the UK by Ney Ltd of Coventry. For more information, call 024 7630 8100, or for a video that shows Bar Nesting and how the Vitap Point K2 Top cuts out sink and tap holes in a kitchen worksurface, download the free Furniture Journal app and touch the picture marked with a link.



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